

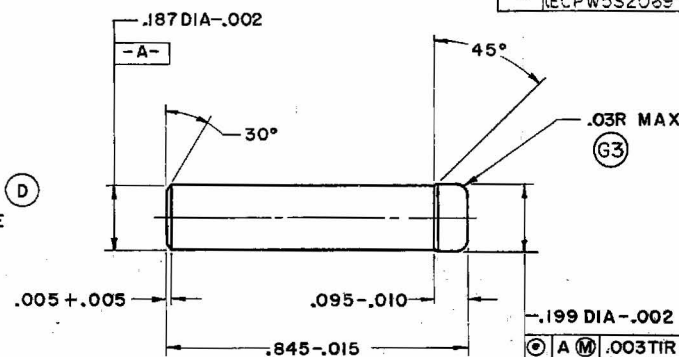
REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
B		11 MAY 55	
C	REDRAWN AND REVISED SEE EO SA 24529	10 JUL 58	<i>Cherry</i>
D	SEE EO SA26974	21 AUG 63	<i>Cherry</i>
E	(1-2) SEE EO SA29262	18 MAY 68	<i>W. P. S.</i>
F	(1-2) SEE EO-82048	11 MAR 68	<i>W. P. S.</i>
G	(1-3) SEE EO HRD 92078-2	25 JUN 68	<i>W. P. S.</i>
H	SEE EO HRD 02138	7 FEB 65	<i>W. P. S.</i>
J	(2) SEE ERR HOR 40681	10 FEB 75	<i>W. P. S.</i>
K	NOR W8S2022/79-03-26	79-04-01	<i>SAR 100</i>
L	NORW452051 / 840824 ECPW5S2069 / 851223)	86C121	<i>SA</i>

1. FINISH <sup>125</sup>✓ ALL OVER. (J)  
2. MATERIAL: STEEL, SPEC  
ASTM A108:1060 THRU 1080. (EI)

3. HEAT TREATMENT: HEAT TO 1500°-1550° F. OIL QUENCH. TEMPER 20 MINUTES AT HEAT NOT LESS THAN 700° F. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED. DECARBURIZATION NOT TO EXCEED .001.

4. FINAL PROTECTIVE FINISH:  
FINISH 5.3.1.2 OF MIL-STD-171.

### 5. MIL-W-13855 APPLIES



ORIGINAL FSCM NO. 19205

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

~~CODE IDENT NO. 19204~~  
PART NO. 5013668

	RIFLE M14NM	PHYSICAL PROPERTIES	UNLESS OTHERWISE SPECIFIED	ORIGINAL DATE OF DRAWING 2 AUG 37
D7790195	RIFLE M14	YP	DIMENSIONS ARE IN INCHES	CHECKED BY N.B.
D6528297	30MLMIC & MID	TS	TOLEANCES ON FRACTIONS DECIMALS ANGLES ± 5°	THICKNESS OF SHEET .003" UNLESS OTHERWISE SPECIFIED
		ELZ	MATERIAL	EXCEPT AS SHOWN
		RA	SEE NOTE 2	SUBMITTED
NEXT ASSY USED ON		BH	HEAT TREATMENT	K.S. Heavy
APPLICATION		RM D55-60	SEE NOTE 3	APPROVED BY CHIEF OF DIVISION
DO NOT APPLY PART NO.			FINISH PROTECTIVE FINISH SEE NOTE 4	CHIEF OF DIVISION R.C. Smith

# PIN HAMMER

~~DEPT OF THE ARMY~~  
~~ROCK ISLAND ARSENAL~~  
~~ROCK ISLAND ILL ILLINOIS~~

DWG SIZE D	501366E
------------------	---------

R.M.F.



M	NORW4S2051 / 840824
	ECPW5S2069 / 851223

860121

REVISIONS			
SYN	DESCRIPTION	DATE	APPROVAL
B		11 MAY 55	
C	REDRAWN AND REVISION SEE EOSA24529	10 MAR 56	R. Hagan
D	SEC EO SA 26658	11 MAR 56	
E	(1-2) SEE EO SA 28282	1 MAR 56	
F	(1-2) SEE EO RIA 14132	4 FEB 56	
G	(1-2) SEE EO -82048	11 MAR 56	
H	(1-2) SEE EO HRD 92078-2	6-25-56	
I	SEE EO HRD 02138	7 FEB 55	
K	SEE ERR HQR 40681	10 FEB 75	SGM
L	NOR WBS2022/79-03-26	79-04-01	SGM

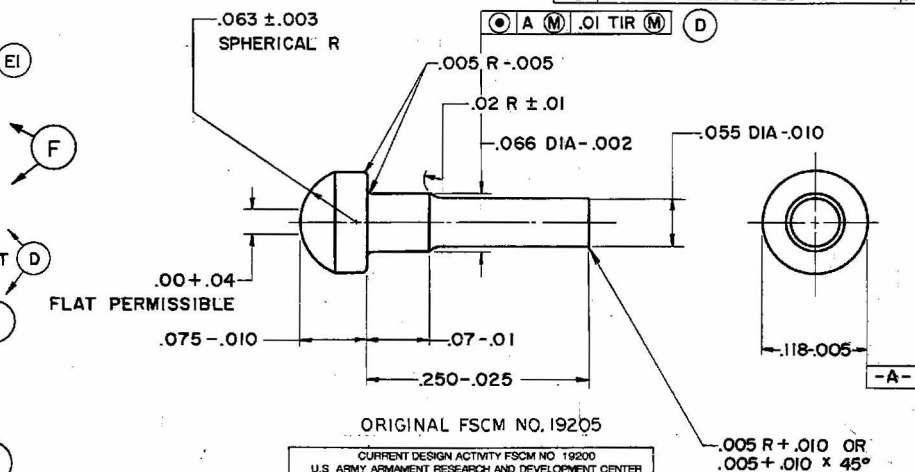
## 1-FINISH 63 ✓

2 - MATERIAL: STEEL, SPEC ASTM  
A575, A576-1060 THRU 1095,  
FINE GRAIN SIZE.

3-HEAT TREATMENT: HEAT T  
IN ACCORDANCE WITH  
SPEC MIL-H-6875.

4- FINISH 5.3.1.2 OR 5.3.2.2  
OF MIL-STD-171.

5. MIL-W-13855 SHALL APPLY.



ORIGINAL FSCM NO. 19205

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

IDENT NO. 19204  
PART NO. 5013671

					PHYSICAL PROPERTIES
		RIFLE, M14NM		YP	
B 6008618		RIFLE, M14		TS	
		308WINMCMID		EL2	
				RA	
				BH	
	NEXT ASSY	USED ON			
	APPLICATION				
DO NOT	APPLY PART NO.			RH	C 45
SW	RET. TO STOCK				TO 50

UNLESS OTHERWISE SPECIFIED		
DIMENSIONS ARE IN INCHES		
TOLERANCES ON		
FRACTIONS	DECIMALS	ANGLES
		$\pm 2^{\circ}$
MATERIAL		
SEE NOTE 2		
HEAT TREATMENT		
SEE NOTE 3		
FINAL PROTECTIVE FINISH		
SEE NOTE 4		

ORIGINAL DATE OF DRAWING		2 AUG 37	
DRAFTSMAN E.J.R.		CHECKER	<i>GTK</i>
TRAGER A.H.Q.		CHECKER	<i>GTK</i>
ENGR <i>Shore</i>		ENGR	<i>D. Lee</i>
SUBMITTED			
<i>R.S. Henry</i>		ORD CORPS	
APPROVED BY CHIEF OF THE CHIEF OF DRAWING			
<i>H.F. Lind</i>		ORD CORPS	

PLUNGER, EXTRACTOR  
SPRING

SCALE: 10/1	UNIT: WT
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~~DEPT OF THE ARMY~~  
~~ROCK ISLAND ARSENAL~~  
~~ROCK ISLAND, ILL 6122~~

DWG SIZE	5013671	
B	SHEET	OF

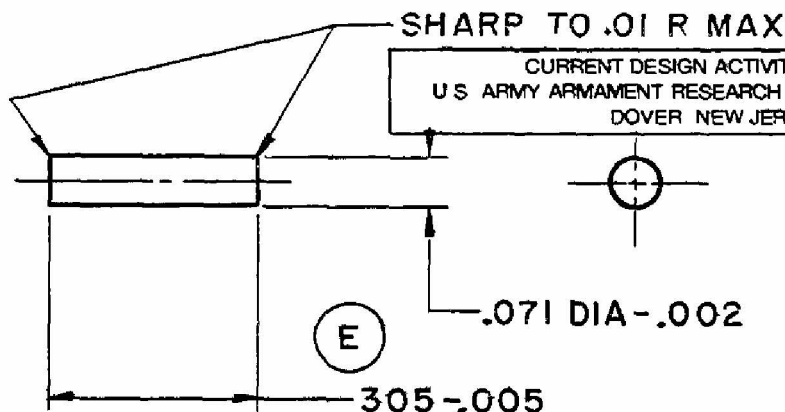
R.M.H.

NOTICE: When Government drawings, specifications, or other data are used for any purpose other than in connection with a definitely related Government procurement operation, the United States Government thereby incurs no responsibility nor any obligation whatsoever, and the fact that the Government may have formulated, furnished or in any way supplied the said drawings, specifications or other data is not to be regarded by implication or otherwise as in any manner licensing the holder or any other person or corporation, or conveying any rights or permission to manufacture, use, or sell any patented invention that may in any way be related thereto.

PHYSICAL PROPERTIES		DO NOT	APPLY PART NO	REVISIONS			
YP		APPLICATION		SYM	DESCRIPTION	DATE	APPROVAL
TS		NEXT ASSY	USED ON	C		25FEB58	
EL2				D	REDRAWN W/O CHANGE	10JUL58	<i>R. Henry</i>
RA				E	SEE EO SA 26654	10DEC62	<i>D. J. Cole</i>
BH		C5546026	RIFLE, M14 NM	F	(1-2) SEE EO SA 29262	18MAY66	<i>D. J. Cole</i>
RH	SEE NOTE	C5546026	30RM, MIC	G	SEE EO 82048	11MAR68	<i>P. Webster</i>
			8 MID	H	(1) SEE EO HRD 92078-2	25JUN69	<i>E. H. Ferguson</i>
				J	SEE EO HRD 02138	71FEB25	<i>D. J. Cole</i>
		C7267090	RIFLE, M14	K	(2) SEE ERR HQR 40681	10FEB75	<i>D. B. Burt</i>
				L	NORW8S2022/79-03-26	790401	<i>SA O. H. Hall</i>
				M	NORW4S2051/840824 (ECP W5S2069/851223)	860121	<i>R. H. Hall</i>

## NOTES:

- (K) (J)
1. FINISH 125/ ALL OVER.
  2. HARDNESS: SUPERFICIAL ROCKWELL 45 N 43-49.
  3. MIL-W-13855 SHALL APPLY.



ORIGINAL FSCM NO 19205

CODE IDENT NO. 19204

PART NO. 5013673

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ON FRACTIONS DECIMALS ANGLES	ORIGINAL DATE OF DRAWING 2 AUG 37	PIN, SEAR	DEPT OF THE ARMY	
	DRAFTSMAN EJR		CHECKER J. H. Hall	ROCK ISLAND ARSENAL
	TRACER M L		CHECKER J. H. Hall	ROCK ISLAND, ILL.
	ENGR J. H. Hall		ENGR J. H. Hall	61201
MATERIAL STEEL CMPSN 1085, SPEC ASTM A108	SUBMITTED			
HEAT TREATMENT	R. S. Henry			
FINAL PROTECTIVE FINISH	APPROVED BY ORDER OF THE CHIEF OF ORDNANCE	SCALE 4/1	DWG SIZE A	5013673
	A. J. Lynch	UNIT WT		SHEET 1 OF 1

RMH

NOTES: WHEN GOVERNMENT DRAWINGS, SPECIFICATIONS OR OTHER DATA ARE USED FOR ANY PURPOSE OTHER THAN IN CONNECTION WITH A DEFINITELY RELATED GOVERNMENT PROCUREMENT OPERATION, THE UNITED STATES GOVERNMENT THEREBY INCURS NO RESPONSIBILITY NOR ANY OBLIGATION WHATSOEVER, AND THE FACT THAT THE GOVERNMENT MAY HAVE FORMULATED, PROVIDED OR IN ANY WAY SUPPLIED THE SAID DRAWINGS, SPECIFICATIONS OR OTHER DATA IS NOT TO BE CONSTRUED BY ANY INDIVIDUAL OR FIRM AS AN IMPLICIT OR EXPLICIT LICENSE OR ANY OTHER PERSON OR CORPORATION, OR CONVEYING ANY RIGHTS OF PERMISSION TO MANUFACTURE OR TO SELL ANY PATENTED INVENTION THAT MAY IN ANY WAY BE RELATED THEREBY.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
C		28 SEP 60	
D	REDRAWN AND REVISED SEE EO SA27441	2 NOV 64	<i>R. Henry</i>
E	(1) SEE EO SA29262	18 MAY 66	<i>J. J. C.</i>
F	(1-2) SEE EO 82048	11 MAR 68	<i>F. Hecker</i>
G	(1) SEE EO HRD 92078-2	25 JUN 69	<i>R. J. C.</i>
H	SEE EO HRD 02138	71 FEB 75	<i>D. W. De</i>
J	SEE ERR HQR 40681	10 FEB 75	<i>H. D. D.</i>
K	NOR W8S2022/79-03-26	79-04-01	<i>S. A. R. H.</i>
L	NORW4S2051/840824 ECPW5S2069 /851223	860121	<i>K. H.</i>

WIRE DIAMETER ----- .0410 ± .0005  
 COIL DIAMETER ( O.D. ) ----- .240 ± .005  
 FREE LENGTH ----- .69 REF  
 TOTAL COILS ----- 9 REF  
 DIRECTION OF HELIX ----- R H  
 LOAD AT COMPRESSED LENGTH OF .47 ----- 17.5 LB ± 2 LB  
 LOAD AT COMPRESSED LENGTH OF .42 ----- 21.5 LB ± 3 LB  
 SPRING RATE ----- 80 LB/IN REF  
 SOLID LENGTH ----- .380 MAX  
 TYPE OF ENDS ----- CLOSED ENDS GROUND  
 MANUFACTURE IN ACCORDANCE WITH MIL-S-13572, TYPE I, GRADE A.

# NOTES:

(J)

- HOLE DIA INTO WHICH SPRING FITS FREELY .257 MIN.
- ROD DIA OVER WHICH SPRING SLIDES FREELY MAX.
- HEAT TREATMENT: STRESS RELIEVE AT 425 °F. TO 445 °F. FOR 30 MIN, AFTER COILING.
- LOAD REQUIREMENTS SHALL APPLY AFTER SPRING HAS BEEN COMPRESSED TO SOLID LENGTH 3 TIMES.

ORIGINAL FSCM NO. 19205

CURRENT DESIGN ACTIVITY FSCM NO. 19206  
 U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
 DOVER, NEW JERSEY 07801

		(E1)		(USED WITH PLATE ASSY, BUTT 7790700 AND PLATE, BUTT, HINGED, ASSY 7313114)		PART NO. 5013747	
						SHORT-DESIGN ARMY ROCK ISLAND ARSENAL ROCK ISLAND, ILL. 61201	
MECHANICAL PROPERTIES		D7790686	RIFLE, M14	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 21 FEB 35	
YP		C7313114	30BARM1918	TOLERANCES ON DECIMALS ±		DRAFTSMAN D.S.K.	
IS			A2	FRACTIONS ± ANGLES ±		CHECKER A.A.C.	
EL 2				MATERIAL: STEEL, WIRE, SPEC QQ-W-470		TRACER W.H.S.	
RA				HEAT TREATMENT		ENGINEER I. M. Schumaker	
BH		NEXT ASSY	USED ON	SEE NOTE 3		SUBMITTER R. J. Henry	
RH		DO NOT	APPLY PART NO	FINAL PROTECTIVE FINISH		APPROVED J. A. Zuckerman	
		AS SPECIFIED		LUB OIL, SPEC VV-L-800			
						CODE IDENT. NO. DWG SIZE 19204 B 5013747	
						SCALE UNIT WT SHEET 1 OF 1	

SARRI Form 40C, 1 May 74

NOTES:

1. FINISH 125/ EXCEPT AS NOTED.
2. ALL CORNERS SHALL BE ROUNDED .005 R + .025 UNLESS OTHERWISE SPECIFIED.
3. HEAT TREATMENT: NORMALIZE BEFORE MACHINING. HEAT TO 1525° TO 1550°F. OIL QUENCH. TEMPER 20 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
4. DIMENSIONS LABELED  $\boxed{-F-}$  SHALL APPLY TO A THEORETICAL SHARP INTERSECTION.
5. MIL-W-13855 SHALL APPLY

CENTER LINE OF APERTURE GROOVE SHALL BE HELD TO 90° 0' ± 0" 15' WITH CENTER LINE OF PINION HOLE AND THREAD.

SEE DETAIL C

DETAIL C  
SCALE: 4/1

DETAIL D  
SCALE: 10/1

DETAIL M  
SCALE 4/1

SEE DETAIL D

SECTION B-B

SECTION A-A  
SCALE: 4/1

CODE IDENT NO.  
19200

CODE IDENT NO. 19204  
PART NO. 5546001

D5546001

REV	DESCRIPTION	DATE	APPROVAL
1	INCORPORATE CHANGES		
2	SEE E.O. 12812		
3	SEE E.O. 12812		
4	SEE E.O. 12812		
5	SEE E.O. 12812		
6	SEE E.O. 12812		
7	SEE E.O. 12812		
8	SEE E.O. 12812		
9	SEE E.O. 12812		
10	SEE E.O. 12812		

PROPERTY	VALUE	PROPERTY	VALUE
1. MATERIAL	STEEL, FED SPEC QQ-S-637-1141	1. MATERIAL	STEEL, FED SPEC QQ-S-637-1141
2. HEAT TREATMENT	SEE NOTE 3	2. HEAT TREATMENT	SEE NOTE 3
3. FINISH	125/	3. FINISH	125/
4. TOLERANCES	UNLESS OTHERWISE SPECIFIED, DECIMALS ARE IN THOUSANDS	4. TOLERANCES	UNLESS OTHERWISE SPECIFIED, DECIMALS ARE IN THOUSANDS
5. DIMENSIONS	UNLESS OTHERWISE SPECIFIED, DECIMALS ARE IN THOUSANDS	5. DIMENSIONS	UNLESS OTHERWISE SPECIFIED, DECIMALS ARE IN THOUSANDS

BASE, REAR SIGHT

5546001

R.M.H.











NOTES:  
1. FINISH <sup>250</sup>✓ EXCEPT AS NOTED.  
2. MATERIAL:

**A FOR WROUGHT MATERIAL:**  
STEEL, ASTM A108, 1021

**B FOR PRECISION CASTING:**  
STEEL, MIL-S-22141:IC-8620  
EXCEPT CARBON .08 TO .18 PERCENT  
OR IC-1020. TENSILE TEST SHALL NOT  
APPLY.

### 3-HEAT TREATMENT:

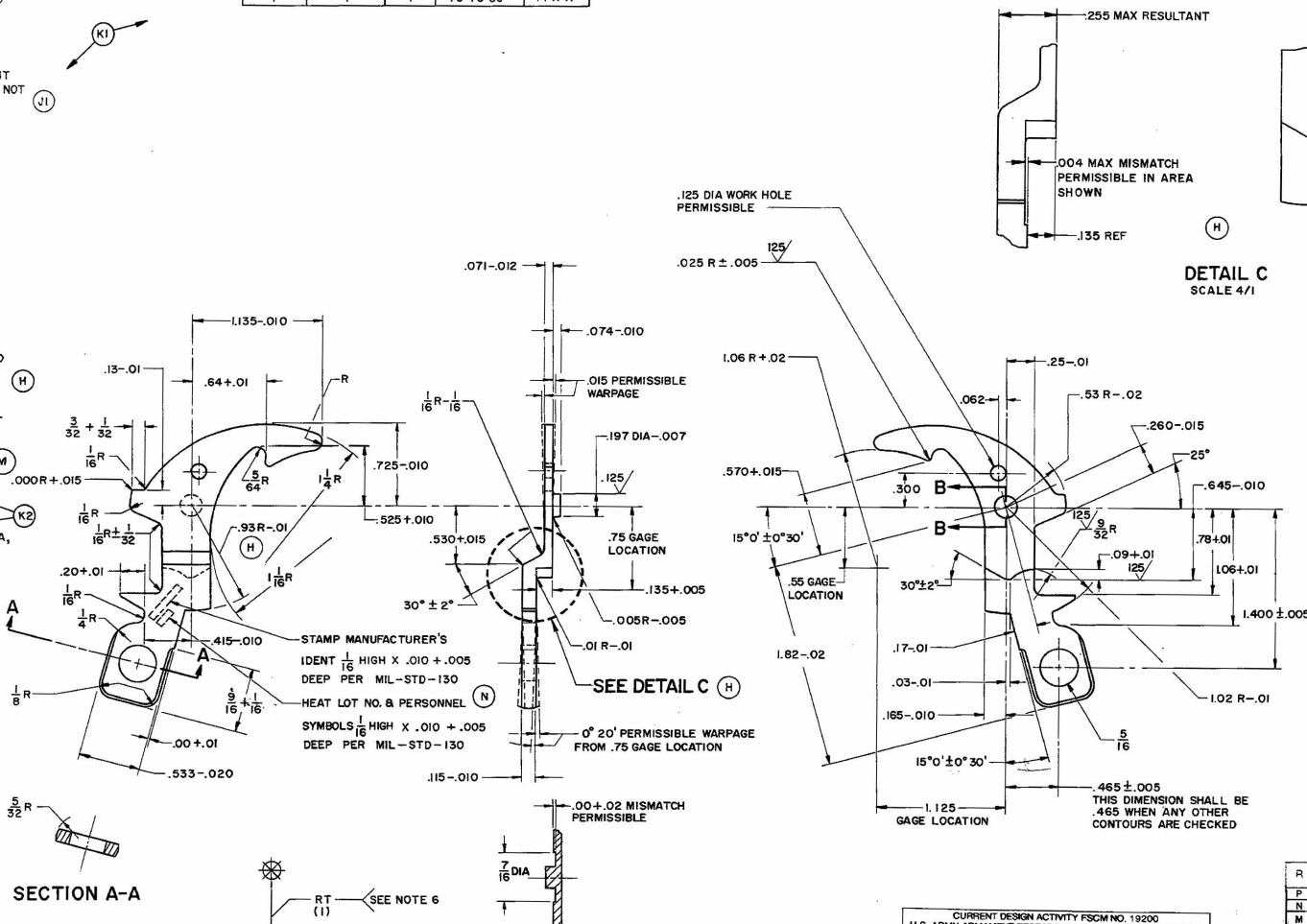
(FOR MATERIALS A AND B)  
NORMALIZE BEFORE MACHINING.  
CARBURIZE AT 1550°-1600°F FROM  
.008 TO .012 DEPTH. OIL QUENCH.  
TEMPER 20 MINUTES AT 350°F.  
HEAT TREATMENT METHOD IS FOR  
GUIDANCE EXCEPT THAT CASE DEPTH  
AND HARDNESS REQUIREMENTS ARE  
MANDATORY, AND TIME AT  
TEMPERATURE SHALL NOT BE REDUCED  
BELOW THAT SPECIFIED. THE USE OF  
STRAIGHT CYANIDE BATH OR CARBO-  
NITRIDING PROCESS SHALL NOT BE  
PERMITTED WITHOUT PRIOR APPROVAL  
OF THE CONTRACTING OFFICER.

4- ALL EDGES SHALL BE BROKEN .005+.010  
UNLESS OTHERWISE SPECIFIED.

5. MIL-W-13855 SHALL APPLY. (G)

6. CLASSIFICATION AND INSPECTION OF INVESTMENT CASTINGS TO BE IN ACCORDANCE WITH CLASS 1, GRADE A MIL-STD-2175.

POSITION NUMBERS	NUMBER OF POSITIONS	NO. OF FILMS	NO. OF VIEWS PER FILM	FILM SIZE
1	1	1	70 TO 80	14 X 17



SECTION A-A

**SECTION B-B**

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

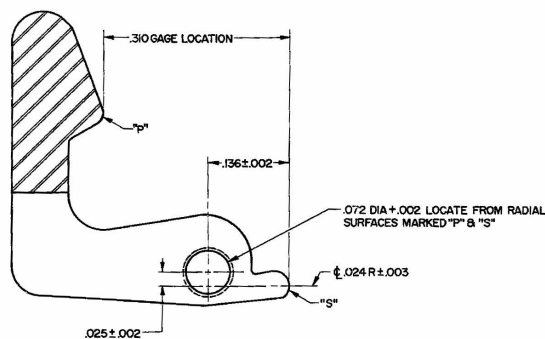
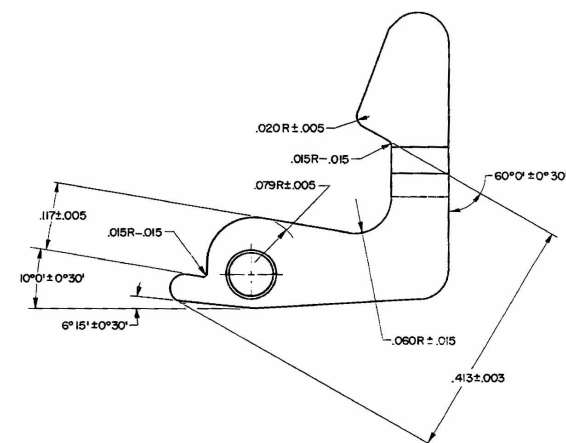
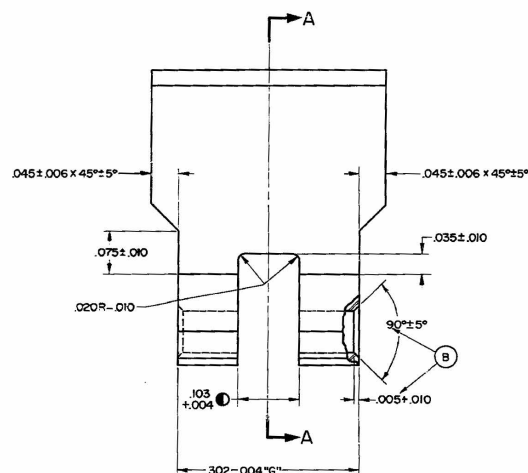
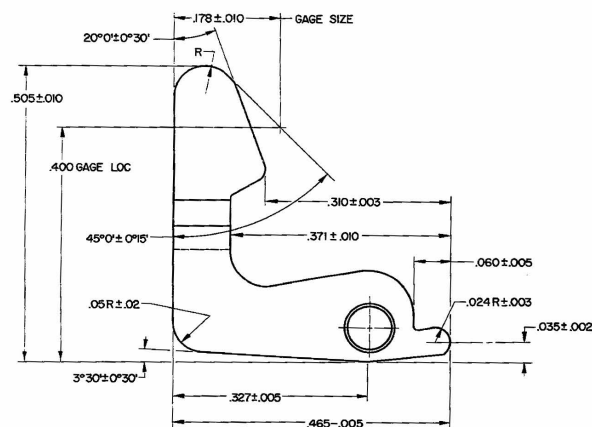
ORIGINAL FSCM NO.19205

CODE IDENT NO. 19204  
PART NO. 5546015

PHYSICAL PROPERTIES		RIFLE, M14		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE 2 APR 37	
TP	07790195	RIFLE, M14		TOLERANCES ON DECIMALS 2:01		OF DRAWING	
ELI	06528297	30R-M1		FRACTIONS 10		DRAWN BY S.H.F. CHECKED J.E.	
PA		MIC & MID		MATERIAL		ENGINEER J.E. ENGINEER J.E.	
				SEE NOTE 2		SUBMITTED	
		NEXT ASY USED ON		HEAT TREATMENT		R. S. Henry	
		APPLICATION		SEE NOTE 3		OCS (COP)	
BY	DO NOT	APPLY PART NO.		FINAL PROTECTIVE FINISH		APPROVED SIGNATURE OF THE	
SEE NOTE 5	00	00		FINISH 5.3.1.2 OF MIL-STD-171		00	

R	ECW552068	858223	260121	21
	NORW455001	840824		
P	NOR W852022	793026	790401	SA
N	(U) SEE ERR HQR	4068L	10 FEB 79	
M	SEE EO MRD	02158	7 FEB 79	
L	(U) SEE EO MRD	82078-2	25 JAN 79	
K	(L-4) SEE EO	82048	1 MAR 79	
H	(L-3) SEE EO	842982	10 MAY 79	
N	SEE EO SA	26343	8 NOV 67	
G	SEE EO SA	25003	1 APR 69	
F	REDHAWN AND REVISED			
E	SEE EO SA	24529	10 JUL 78	
			23 NOV 78	
ST				
DESCRIPTION		DATE	APPROVAL	
REVISIONS				
CHECKS OF THE ARMY				
ROCK ISLAND AND ARSENAL				
ROCK ISLAND, ILL. AREA				
SAFETY				
PAGE		5546015		
D				

D5546016



SECTION A-A

E  
NOTES:

1. MIL-W-13855 APPLIES.
2. FINISH ALL OVER  $\sqrt{63}$ .
3.  $\bullet$  SHALL BE CENTRAL WITH DIMENSION  $\pm 0.002$  WITHIN  $\pm 0.002$ .
4. HEAT TREATMENT: CARBURIZE  $.010-.015$  DEEP. HEAT TO  $1550^{\circ}\text{F}$  -  $1600^{\circ}\text{F}$  OIL QUENCH. TEMPER 20 MINUTES AT  $350^{\circ}\text{F}$ .
5. MATERIAL: STEEL, SPEC QQ-S-624; 8620 EXCEPT: SULPHUR  $.035-.050$  (RESULPHURIZED). AUSTENITIC GRAIN SIZE 5 OR FINER.

PHYSICAL PROPERTIES		TOLERANCES ON DIMENSIONS		ORIGINAL DATE	
TEMP.		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		1937	
TEMP.		DECIMALS		1937	
TEMP.		FRACTIONS		1937	
TEMP.		SEE NOTE 5		1937	
TEMP.		HEAT TREATMENT		1937	
TEMP.		SEE NOTE 4		1937	
TEMP.		FINAL PROTECTIVE FINISH		1937	
TEMP.		FINISH 5.3.12 OF MIL-STD-171		1937	

CODE IDENT 19204  
PART NO. 5546016

REVISIONS	DATE	APPROVAL
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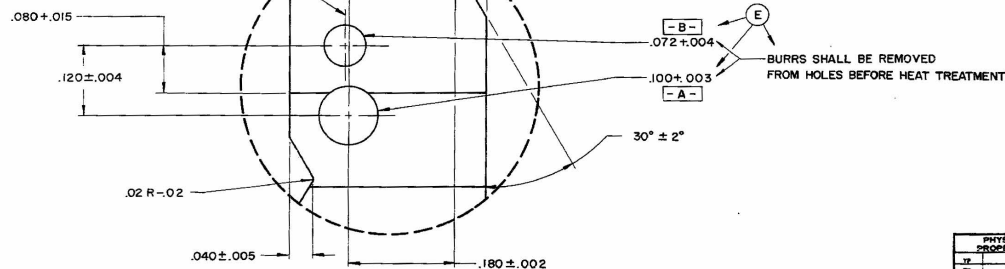
SEAR

DEPT OF THE ARMY  
ROCK ISLAND ARSENAL  
ROCK ISLAND, ILL. 61201  
D 5546016  
SHEET 1 OF 1

NOTES:

1. FINISH 125/ EXCEPT AS NOTED.
2. ALL EDGES AND CORNERS SHALL BE BROKEN .005+ .010 UNLESS OTHERWISE SPECIFIED.
3. MATERIAL: STEEL, SPEC ASTM A304, A322, A331; 8620 EXCEPT; SULPHUR .035-.050 (RESULPHURIZED). AUSTENITIC GRAIN SIZE 5 OR FINER.
4. HEAT TREATMENT: NORMALIZE BEFORE MACHINING. CARBURIZE AT 1600°F ± 25°F FROM .008 TO .012 DEPTH. OIL QUENCH. TEMPER 30 MINUTES AT 350°F TO 375°F. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED. THE USE OF STRAIGHT CYANIDE BATH OR CARBO-NITRIDING PROCESSES SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF THE CONTRACTING OFFICER.
5. LINE [-F-] PASSES THROUGH THE THEORETICAL APEX FORMED BY SURFACES [-J-] AND [-K-].
6. MIL-W-13855 SHALL APPLY.
7. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171 LIGHT GRITBLAST PERMISSIBLE

VERTICAL C'S OF HOLES [-A-] AND [-B-] SHALL COINCIDE WITHIN .003



DETAIL B  
SCALE 10/1

THESE SURFACES SHALL BE IN ALIGNMENT WITH EACH OTHER WITHIN .002, WITHIN DIMENSIONAL LIMITS, AND 90° 0' ± 0° 10' FROM SURFACE [-E-]

THIS CORNER SHALL BE SHARP AND SMOOTH BOTH SIDES

THIS SURFACE SHALL BE SMOOTH, FLAT AND 90° 0' ± 0° 10' FROM C[-D-]

SECTION A-A

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

ORIGINAL FSCM NO. 19205

CODE IDENT NO. 19204  
PART NO. 5546020

<b>PHYSICAL PROPERTIES</b> C7267090 RIFLE M14 C5546026 RIFLE M14/M16 SEE NOTE 6 FILE HARD		<b>APPLICATION</b> DO NOT APPLY PART NO. 5546026		<b>HEAT TREATMENT</b> SEE NOTE 4		<b>FINAL PROTECTIVE FINISH</b> SEE NOTE 7	
<b>DESIGN PROPERTIES</b> C7267090 RIFLE M14 C5546026 RIFLE M14/M16 SEE NOTE 6 FILE HARD		<b>DESIGN PROPERTIES</b> C7267090 RIFLE M14 C5546026 RIFLE M14/M16 SEE NOTE 6 FILE HARD		<b>DESIGN PROPERTIES</b> C7267090 RIFLE M14 C5546026 RIFLE M14/M16 SEE NOTE 6 FILE HARD		<b>DESIGN PROPERTIES</b> C7267090 RIFLE M14 C5546026 RIFLE M14/M16 SEE NOTE 6 FILE HARD	

M	ECWP552059 / 851223	860121	
L	NORW452051/840824		
K	(3) SEE ERM HQR 40681	10 FEB 79	
J	SEE EO HRD 02138	11 FEB 79	
H	(1) SEE EO HRD 82078-2	25 JAN 79	
G	(1-3) SEE EO 82048	11 MAR 79	
F	(1) SEE EO SA 29261	10 MAR 79	
E	SEE EO SA 29263	10 MAR 79	
D	REDRAWN AND REVISED	10 MAR 79	
C	SEE EO SA 24529	10 MAR 79	
B			
A			

TRIGGER

5546020

SCALE 2/1 UNIT WT

RMH

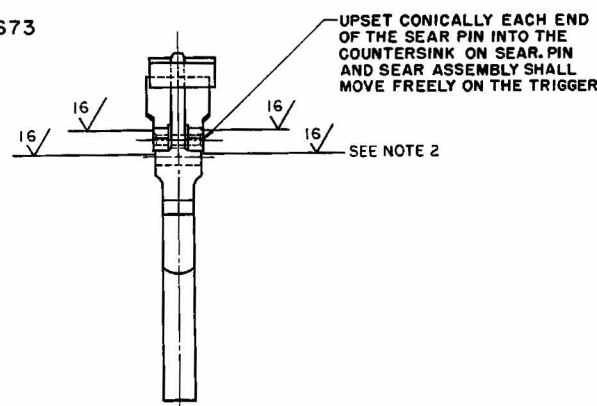
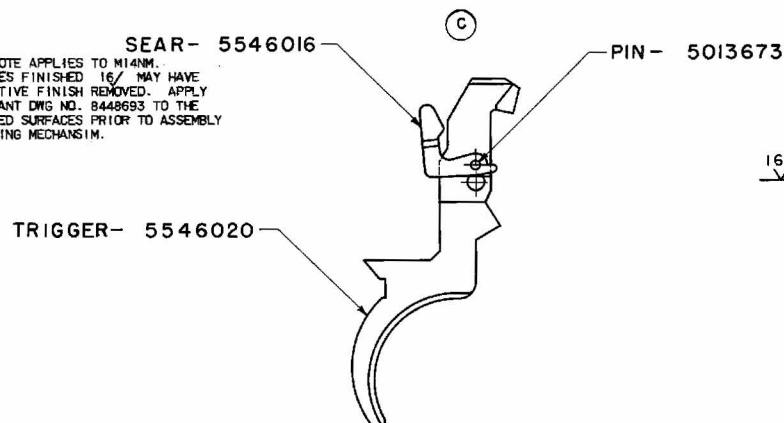
# LIST OF COMPONENTS

1	2	3	4
LINE NO.	DRAWING NUMBER	NAME OF COMPONENT	NO. REQ.
1	C5546026	TRIGGER, ASSEMBLY	1
2		COMPOSED OF:	
3	A5013673	1 - PIN, SEAR	
4	D5546016	1 - SEAR	
5	D5546020	1 - TRIGGER	

## NOTES:

MIL-W-13855 SHALL APPLY. (B)

2. THIS NOTE APPLIES TO M14MM. SURFACES FINISHED 16/ MAY HAVE PROTECTIVE FINISH REMOVED. APPLY LUBRICANT DNG NO. 8448693 TO THE FINISHED SURFACES PRIOR TO ASSEMBLY IN FIRING MECHANISM.



NOTICE: THIS DRAWING SHALL NOT BE REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

ORIGINAL DESIGN ACTIVITY FSCM NO.19205  
CURRENT DESIGN ACTIVITY FSCM NO.19200  
US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

PART NO. 5546026

PHYSICAL PROPERTIES	9354354	M14MM RIFLE 7.62MM
VP		
TS		
SLZ	D6528297	30R-MI, MIC
NA		8 MID
BN		RENT ARSY USED ON
W:	DO NOT	APPLY PART NO.
		10 SPECIFY

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES  
TOLERANCES ON DECIMAL FRACTIONS  
ANGLES  
MATERIAL  
HEAT TREATMENT  
FINAL PROTECTIVE FINISH

ORIGINAL DATE OF DRAWING AUG 2, 1937  
DRAFTSMAN E. J. R. CHECKED J. P. H.  
TRACER C. J. D. ALI CHECKER J. P. H.  
ENGINEER R. C. A. ENGINEER J. P. H.  
SUBMITTED  
APPROVED BY ORIGINATOR OF THE CHIEF OF ORDNANCE  
SCALE 2/1 UNIT WT .04

TRIGGER ASSEMBLY

DEPT OF THE ARMY  
ROCK ISLAND ARSENAL  
ROCK ISLAND, ILL 62401

DWG NO. 5546026

C SHEET 1 OF 1  
AE

C 5546026

NOTICE—When Government drawings, specifications, or other data are used for any purpose other than in connection with a definitely related Government procurement contract, the United States Government thereby incurs no responsibility nor any obligation whatsoever; and the fact that the Government may have furnished, furnished, or supplied the said drawings, specifications, or other data is not to be regarded by implication or otherwise as in any manner licensing the holder or any other person or organization, or conveying any rights or permission to manufacture, use, or sell any patented invention that may in any way be related thereto.

## NOTES:

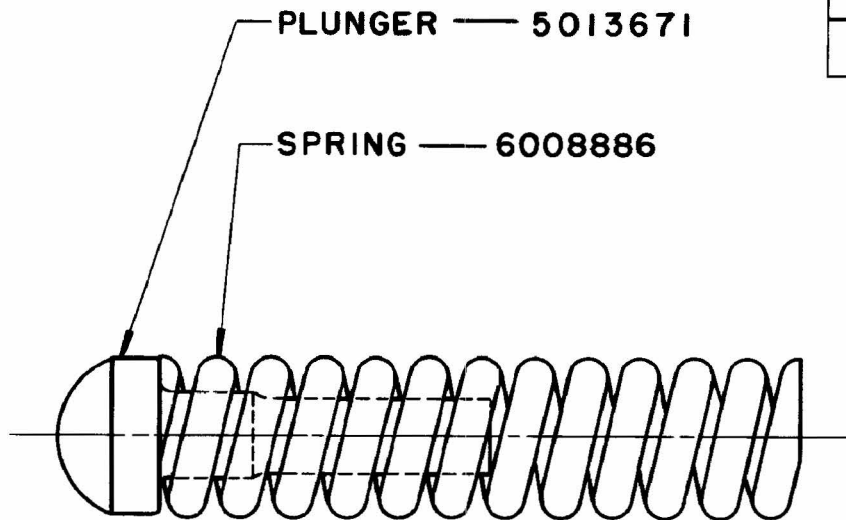
I. MIL-W-13855 SHALL APPLY.

8198009B

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
A		9 JAN 53	
B	REDRAWN W/O CHANGE	10 JUL 56	<i>R. S. Henry</i>
C	SEE EO SA 26974	21 AUG 63	<i>R. S. Henry</i>
D	SEE EO SA 29261	18 MAY 66	<i>R. S. Henry</i>
E	SEE EO 82048	11 MAR 68	<i>R. S. Henry</i>
F	(I) SEE EO HRD 92078-2	25 JUN 68	<i>R. S. Henry</i>
G	SEE EO HRD 02138	7 FEB 75	<i>R. S. Henry</i>
H	NOR W8S2022/79-03-26	79-04-01	<i>S. A. P. Hall</i>
J	NORW4S2051/840824 ECPW5S2069/851223	860121	<i>R. S. Henry</i>

PLUNGER — 5013671

SPRING — 6008886



ORIGINAL FSCM NO. 19205

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

(F1)

FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 6008618

		(G)		CODE IDENT NO. <del>19204</del>		PART NO. 6008618		(E)	
RIFLE, M4MM		PHYSICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED		ORIGINAL DATE OF DRAWING 2 AUG 37		PLUNGER, EXTRACTOR SPRING, ASSEMBLY	
C7790187 RIFLE, M14		YP		DIMENSIONS ARE IN INCHES		DRAFTSMAN A.G.L. CHECKER <i>R.S.H.</i>			
30R-M1, MIC		TS		TOLERANCES ON FRACTIONS DECIMALS ANGLES		TRACER <i>R.S.H.</i> CHECKER <i>R.S.H.</i>			
D5546023 8 MID		EL2		MATERIAL		ENGR <i>R.S.H.</i> ENGR <i>R.S.H.</i>			
NEXT ASSY		RA		HEAT TREATMENT		SUBMITTED		DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILL. 61201	
USED ON		BH		FINAL PROTECTIVE FINISH		APPROVED BY ORDER OF THE CHIEF OF ORDNANCE			
APPLICATION		RH				R. S. Henry ORG CORPS			
DO NOT		APPLY PART NO.				H. J. Lynch ORG CORPS		DWG SIZE	
AS SPECIFIED								B	
								6008618	
								SCALE 10/1 UNIT WT	
								SHEET 1 OF 1	

RMH

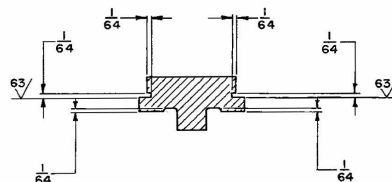
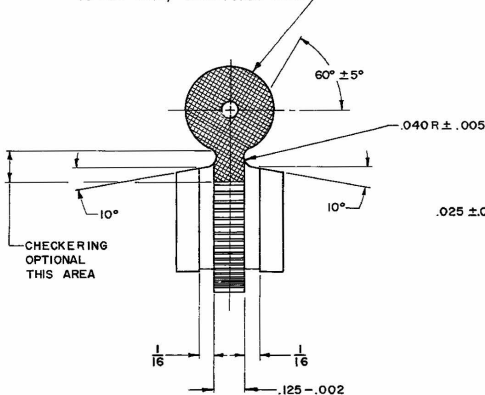
1178

NOTES: THESE DIMENSIONS, DIMENSIONS, OR OTHER DATA ARE USED FOR THE PURPOSES OF THIS DRAWING ONLY. THEY ARE NOT TO BE USED FOR THE PURPOSES OF ANY OTHER DRAWING. THE UNITED STATES GOVERNMENT MAKES NO WARRANTY, EXPRESS OR IMPLIED, FOR THE ACCURACY, COMPLETENESS, OR SUITABILITY OF ANY INFORMATION CONTAINED HEREIN. THE UNITED STATES GOVERNMENT SHALL NOT BE LIABLE FOR ANY DAMAGES, INCLUDING REASONABLE ATTORNEY'S FEES, ARISING OUT OF OR RESULTING FROM THE USE OF ANY INFORMATION CONTAINED HEREIN, EVEN IF ADVISED OF THE POSSIBILITY OF SUCH DAMAGE. THE UNITED STATES GOVERNMENT SHALL NOT BE LIABLE FOR ANY DAMAGES, INCLUDING REASONABLE ATTORNEY'S FEES, ARISING OUT OF OR RESULTING FROM THE USE OF ANY INFORMATION CONTAINED HEREIN, EVEN IF ADVISED OF THE POSSIBILITY OF SUCH DAMAGE.

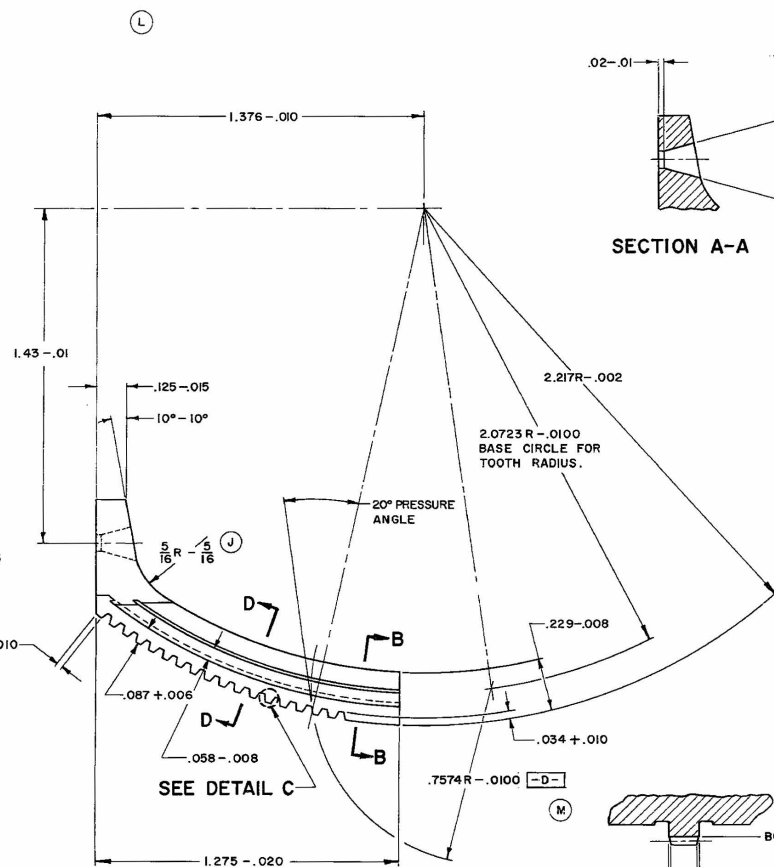
# NOTES:

1. FINISH 125/ EXCEPT AS NOTED.
2. MATERIAL: STEEL, FED. SPEC Q0-S-637/1141 FORGING (NI)  
SPEC MIL-S-46172; STEEL TUBING, SEAMLESS, SPEC ASTM A512, A513, A519, 1040.
3. HEAT TREATMENT: HEAT TO 1525° - 1550°F. OIL QUENCH. TEMPER 20 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
4. ALL CORNERS AND EDGES SHALL BE BROKEN .005 ± .010 UNLESS OTHERWISE SPECIFIED.
5. MIL-W-13855 SHALL APPLY.

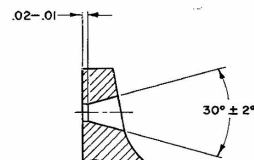
FINE CHECK - 90° ± 5° INCL ANGLE  
60 PER INCH, -.003 ± .005 DEEP



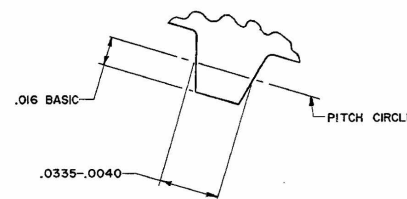
SECTION B-B



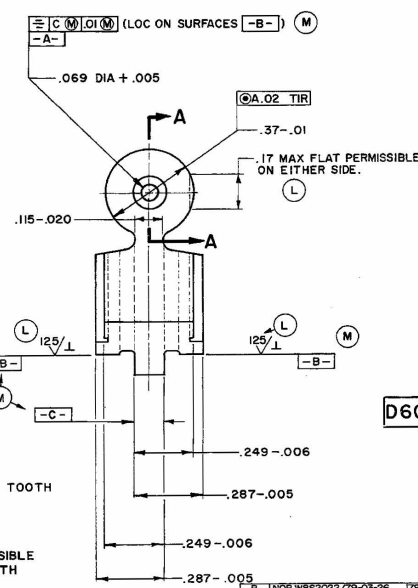
CUT IT SPACES - MODIFIED (D-)  
NUTTALL 20 DEGREE STUB TEETH  
220 TEETH IN COMPLETE CIRCLE  
50 PER INCH .0628 CIRCULAR  
PITCH. 2.200 PITCH RADIUS  
ACCUMULATED BUILDUP OF  
TOLERANCE IN CIRCULAR PITCH  
SHALL NOT EXCEED .005 IN 7 TEETH.



SECTION A-A



DETAIL C  
SCALE 30/1



SECTION D-D U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND  
DOVER, NEW JERSEY 07801

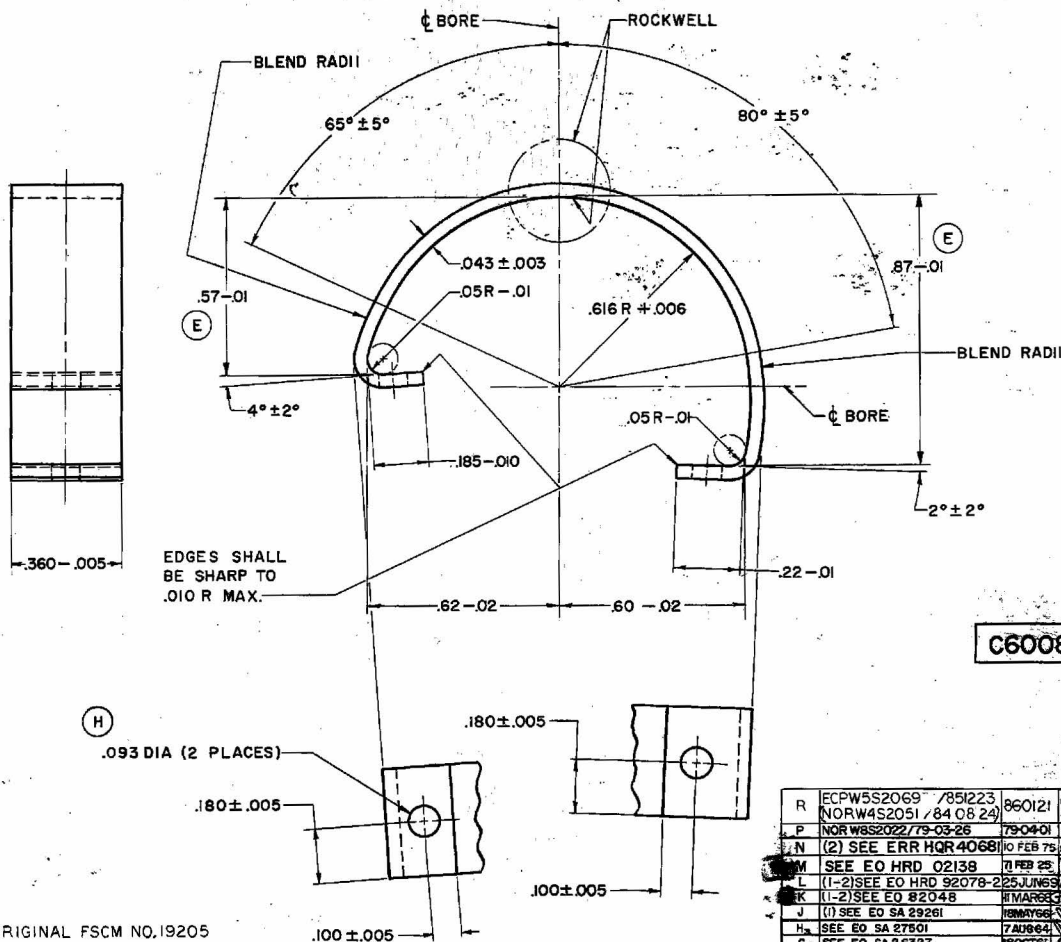
19200  
PART NO. 6008868

PHYSICAL PROPERTIES		TOLERANCES ON DECIMALS		ORIGINAL DATE OF DRAWING	
ITEM	DESCRIPTION	FRAC	DEC	DATE	BY
1	F7267000 RIFLE M14	1/100	0.01	2 AUG 37	CHARTERED L. L. L.
2	F7267000 30R-MID	1/100	0.01		
3	F7265699 30R-MIC	1/100	0.01		
4	F7265698 30R-MI	1/100	0.01		
5	C40-45	1/100	0.01		
APPLICATION		HEAT TREATMENT		APPROVED BY	
DO NOT APPLY PART NO.		SEE NOTE 3		A. J. Henry	
FINISH 5.3.1.2 OF MIL-STD-171		FINISH 5.3.1.2 OF MIL-STD-171		H. J. Henry	
APERTURE		APERTURE		SCALE 4/1 UNIT WT. 02	
DEPT. OF THE ARMY		DEPT. OF THE ARMY		SHEET 1 OF 1	
ROCK ISLAND ARSENAL		ROCK ISLAND ARSENAL		R. M. H.	
6008868		6008868			



NOTES:

1. FINISH  $\sqrt{25}$  ALL OVER.
2. BREAK ALL EXTERNAL CORNERS AND EDGES .005 R + .020 UNLESS OTHERWISE SPECIFIED.
3. MATERIAL: STEEL, ASTM A684, 1070 THRU 1085.
4. HEAT TREATMENT: HEAT TO 1500°-1550° F. OIL QUENCH. TEMPER 20 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
5. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.
6. MIL-W-13855 SHALL APPLY.



ORIGINAL FSCM NO. 19205  
CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

CODE IDENT NO. 19204  
PART NO. 6008870

R	ECPW5S2069 / 851223	860121	
P	NORW4S2051 / 84 08 24	79-04-01	
N	(2) SEE ERR HQR 40681	10 FEB 75	
M	SEE EO HRD 02138	71 FEB 25	
L	(1-2) SEE EO HRD 92078-225	JUN 69	
K	(1-2) SEE EO 82048	11 MAR 63	
J	(1) SEE EO SA 29261	11 MAY 66	
H	SEE EO SA 27501	7 AUG 64	
G	SEE EO SA 26327	19 OCT 61	
F	SEE EO SA 25327	1 SEP 59	
E	SEE EO SA 25008	3 FEB 59	
D	REDRAWN AND REVISED SEE	10 JUL 56	
C	EO SA 24529	3 JUN 57	
SYN	DESCRIPTION	DATE	APPROVAL

PHYSICAL PROPERTIES	OTHER SPECIFICATIONS	TOLERANCES ON DECIMALS ± .01	ORIGINAL DATE OF DRAWING 2 AUG 37
VP C9352721	RIFLE, M14NM	ANGLES FRACTIONS	DRAFTSMAN D.H. CHECKER
TS C7791286	RIFLE, M14	MATERIAL	TRADER W.S. CHECKER
EL 2 C5546024	30R-MI-MIG	SEE NOTE 3	ENGINEER L.S. ENGINEER
RA		HEAT TREATMENT	SUBMITTED
BH	NEXT ASST USED ON	SEE NOTE 4	R.S. Henry
RH C45-50	APPLICATION	FINAL PROTECTIVE FINISH	ORD CORPS
	DO NOT APPLY PART NO.	SEE NOTE 5	APPROVED BY ORDER OF THE

BAND, REAR  
HAND GUARD

DEPT OF THE ARMY  
ROCK ISLAND ARSENAL  
ROCK ISLAND, ILLINOIS 61206  
6008870

R.M.H.

NOTES:

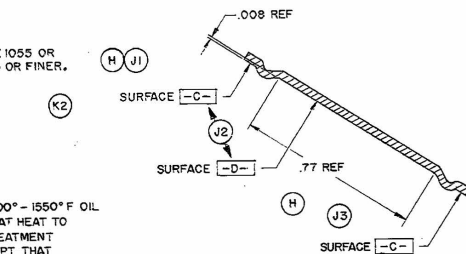
1. FINISH 125/ EXCEPT AS NOTED.
2. MATERIAL: STEEL, ASTM A684: 1055 OR 1065, AUSTENITIC GRAIN SIZE 5 OR FINER.

3. HEAT TREATMENT: HEAT TO 1500° - 1550° F OIL QUENCH, TEMPER 20 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.

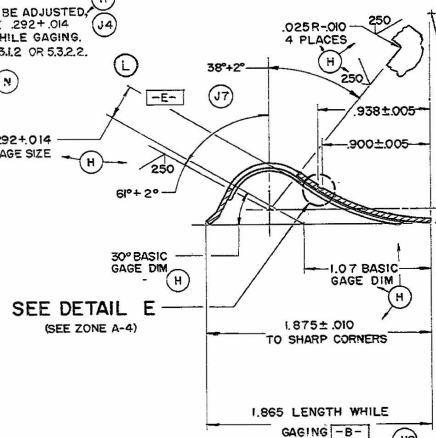
4. ALL EDGES SHALL BE BROKEN .005 MAX AND FREE OF BURRS.

5. DIMENSIONS [F-] SHALL BE ADJUSTED, WITHIN TOLERANCE, TO PRODUCE .292 ± .014 GAGE SIZE AT 1.865 LENGTH WHILE GAGING.
6. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.

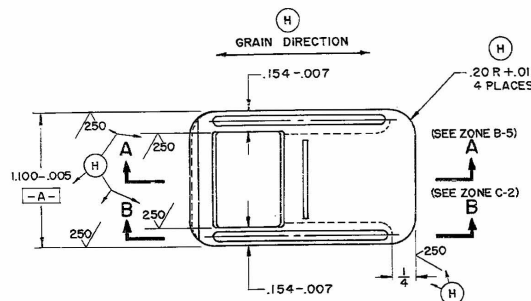
7. MIL-W-13855 SHALL APPLY.



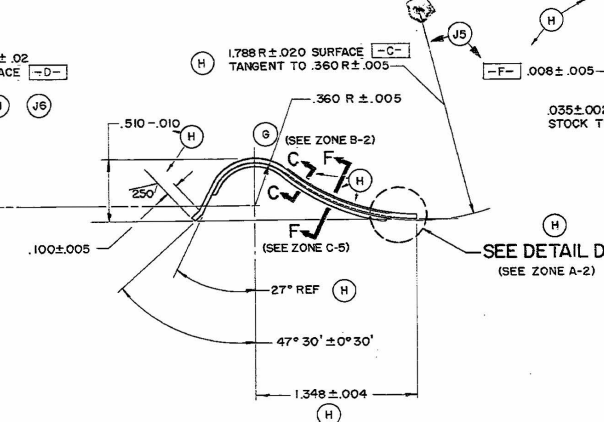
SECTION F-F  
SCALE 4/1  
(SEE ZONE B-3)



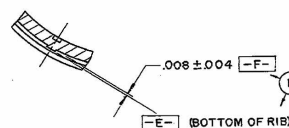
SECTION A-A  
(SEE ZONE D-3)



SECTION B-B  
(SEE ZONE D-3)



SECTION C-C  
SCALE 4/1  
(SEE ZONE C-3)



DETAIL E  
SCALE 4/1  
(SEE ZONE B-5)

SURFACE [C-] SHALL BE BLENDED INTO SURFACE [D-] BETWEEN THE .15/64 AND .19-.04 DIMENSIONS.

DETAIL D  
SCALE 10/1  
(SEE ZONE B-2)

PHYSICAL PROPERTIES	F7267000 RIFLE M14	ORIGINAL DATE: 2 AUG 37
IF	F7265700 130R-MID	OF DRAWING
IS	F7265699 130R-MIC	CHARTERED J. B. CHARTER
ALC	F7265698 130R-MI	TRAILER G. P. L. CHECKER
MA	J5386974 RIFLE M14/M	ENGINEER
IN		DESIGNER
PR	A73-76	DO NOT APPLY PART NO.
		HEAT TREATMENT
		SEE NOTE 3
		FINAL PROTECTIVE FINISH
		SEE NOTE 6

ORIGINAL FSCM NO. 19205

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

PART NO. 6008872

COVER,  
REAR SIGHT

6008872

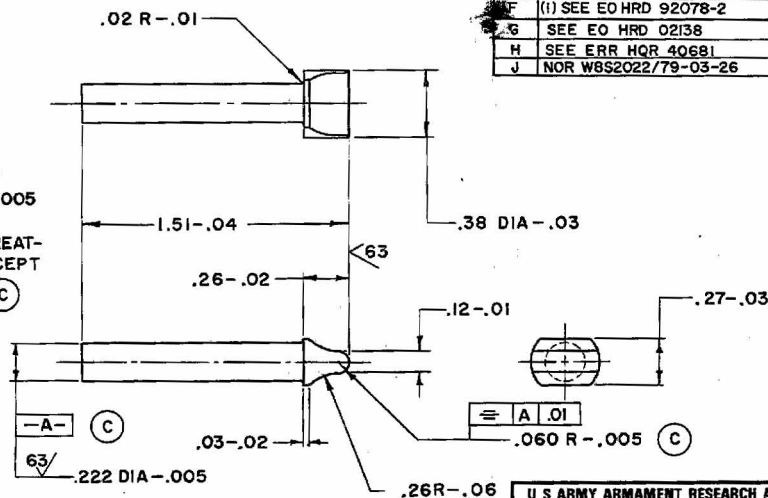
SHEET 1 OF 1

08880098

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
A		1 SEP 53	
B	REDRAWN AND REVISED SEE EO SA 24529	10 JUL 58	<i>R. S. Henry</i>
C	SEE EO SA 26563	23 NOV 62	<i>R. S. Henry</i>
D	(1-3) SEE EO SA 29262	18 MAY 66	<i>R. S. Henry</i>
E	(1-2) SEE EO 82048	11 MAR 68	<i>R. S. Henry</i>
F	(1) SEE EO HRD 92078-2	25 JUN 69	<i>R. S. Henry</i>
G	SEE EO HRD 02138	21 FEB 75	<i>R. S. Henry</i>
H	SEE ERR HQR 40681	10 FEB 75	<i>R. S. Henry</i>
J	NOR W852022/79-03-26	79-04-01	SA R. H. H.

## NOTES:

1. FINISH  $125/\sqrt{\text{IN}}$  EXCEPT AS NOTED.
2. MATERIAL: STEEL, SPEC QQ-S-637-BIII2, III7 (FOR MACHINING METHOD). STEEL, SPEC ASTM A575, A576 OR ASTM A108:1020 (FOR COLD HEADING).
3. HEAT TREATMENT: CARBURIZE AT 1550° TO 1600°F FROM .003 TO .005 DEPTH. OIL QUENCH. TEMPER 20 MINUTES AT 350° F. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED. THE USE OF STRAIGHT CYANIDE BATH OR CARBO-NITRIDING PROCESSES SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF THE CONTRACTING OFFICER.
4. ALL EDGES SHALL BE BROKEN .005+.015 UNLESS OTHERWISE SPECIFIED.
5. MIL-W-13855 SHALL APPLY.



CODE IDENT NO.

19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND  
DOVER, NEW JERSEY 07801

PART NO. 6008880

RIFLE, M21	PHYSICAL PROPERTIES
RIFLE, M14	YP
D7790195	TS
D 6528297	EL2
30R-MI	RA
MIC & MID	BH
USED ON	RM
APPLICATION	
DO NOT	APPLY PART NO.
FILE	HARD

UNLESS OTHERWISE SPECIFIED		
DIMENSIONS ARE IN INCHES	TOLERANCES ON	ANGLES
FRACTIONS	DECIMALS	
MATERIAL SEE NOTE 2		
HEAT TREATMENT SEE NOTE 3		
FINAL PROTECTIVE FINISH		
FINISH NO. 6.3.1.2 OF		
MIL-STD-171		

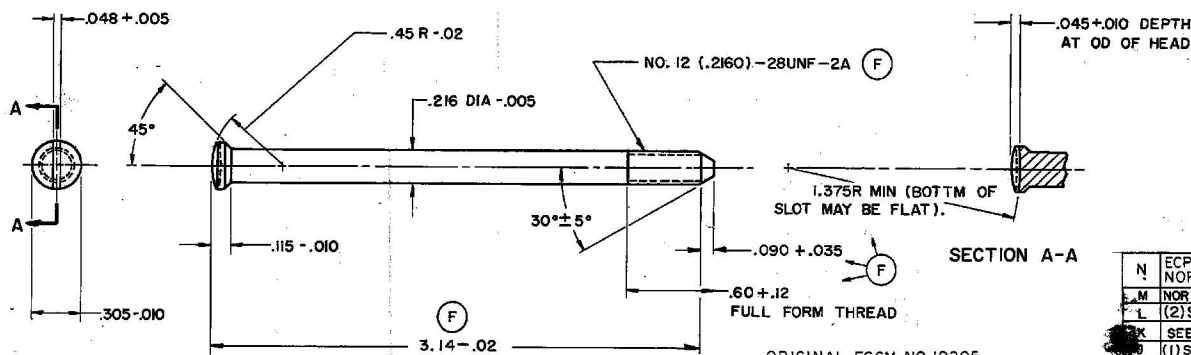
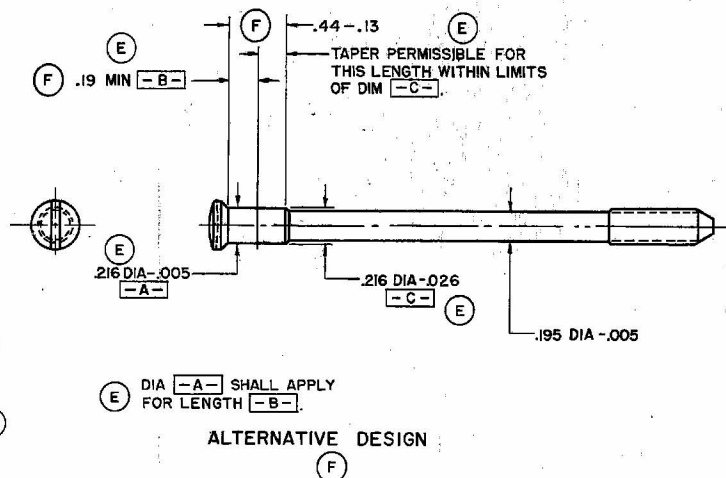
ORIGINAL DATE OF DRAWING	2 AUG 37
DRAFTSMAN	H. D. C.
CHECKER	<i>R. S. Henry</i>
TRACER	C. C. G.
CHECKER	<i>R. S. Henry</i>
ENGINEER	<i>R. S. Henry</i>
SUBMITTED	<i>R. S. Henry</i>
APPROVED BY ORDER OF THE	<i>R. S. Henry</i>
CHIEF OF DESIGN	<i>R. S. Henry</i>
APPROVED	<i>R. S. Henry</i>

PLUNGER,  
HAMMER SPRINGDEPT OF THE ARMY  
ROCK ISLAND ARSENAL  
ROCK ISLAND, ILL 61201DWG  
SIZE  
B  
6008880  
SHEET 1 OF 1

R. M. H.

NOTES:

1. FINISH 125/ALL OVER. (L)
2. MATERIAL: STEEL, ASTM A108  
1018 THRU 1020 OR SPEC QQ-S-637;  
1117. (G1)
3. HEAT TREATMENT: CARBURIZE AT  
1550° TO 1600° F FROM .003 TO .005  
DEPTH. OIL QUENCH. TEMPER 20 MIN  
AT 350° F. HEAT TREATMENT METHOD  
IS FOR GUIDANCE EXCEPT THAT CASE  
DEPTH AND HARDNESS REQUIREMENTS  
ARE MANDATORY AND TIME AT TEMPER-  
ATURE SHALL NOT BE REDUCED BELOW  
THAT SPECIFIED. (E)
4. ALL CORNERS AND EDGES SHALL BE  
FREE OF BURRS. (H)
5. MIL-W-13855 SHALL APPLY. (H)



ORIGINAL FSCM NO. 19205

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

PART NO. 6008881

PHYSICAL PROPERTIES	9392337	RIFLE, M14-NM
ITEM	F11010264	RIFLE, M14
TS	F11686428	30R, M, MIC, MID
EL 2	D6535468	
RA		
BN		
NR		
FILE HARD		

APPLICATION	DO NOT	APPLY PART NO.
HEAT TREATMENT	SEE NOTE 3	
FINAL PROTECTIVE FINISH	FINISH NO. 5.34.2 OR 5.3.2.2	OF MIL-STD-171

ORIGINAL DATE OF DRAWING	2 AUG 37
DESIGNER	H. D. C.
CHECKER	SEE NOTE 2
ENGINEER	SEE NOTE 2
SUBMITTED	SEE NOTE 2
APPROVED BY	R. S. Henry
DATE	2 AUG 37

SCALE	2/1
UNIT WT.	.03
RMH	

DEPT OF THE ARMY	
ROCK ISLAND ARSENAL	
6008881	

N	ECWP5S2069 /851223 NORW432051/840824	860121	R1
M	NOR W832022/79-03-26	790401	SAC <i>W. J. ...</i>
L	(2) SEE ERR HQR 40681	10 FEB 75	<i>W. J. ...</i>
K	SEE EO HRD 02138	7 FEB 75	<i>W. J. ...</i>
J	(1) SEE EO HRD 92078-2	25 JUN 69	<i>W. J. ...</i>
H	(1-3) SEE EO 82048	11 MAR 68	<i>W. J. ...</i>
G	(1-2) SEE E0 SA29262	18 MAY 68	<i>W. J. ...</i>
F	SEE E0 SA 27473	25 JUN 68	<i>W. J. ...</i>
E	REF EO NO. SA 26895	21 JUN 63	<i>W. J. ...</i>
D	SEE E0 SA 25327	1 SEP 58	<i>W. J. ...</i>
C	REDRAWN AND REVISED SEE EO SA24529	10 JUL 58	<i>W. J. ...</i>
B	EO SA24529	3 MAR 54	
SYN	DESCRIPTION	DATE	APPROVAL

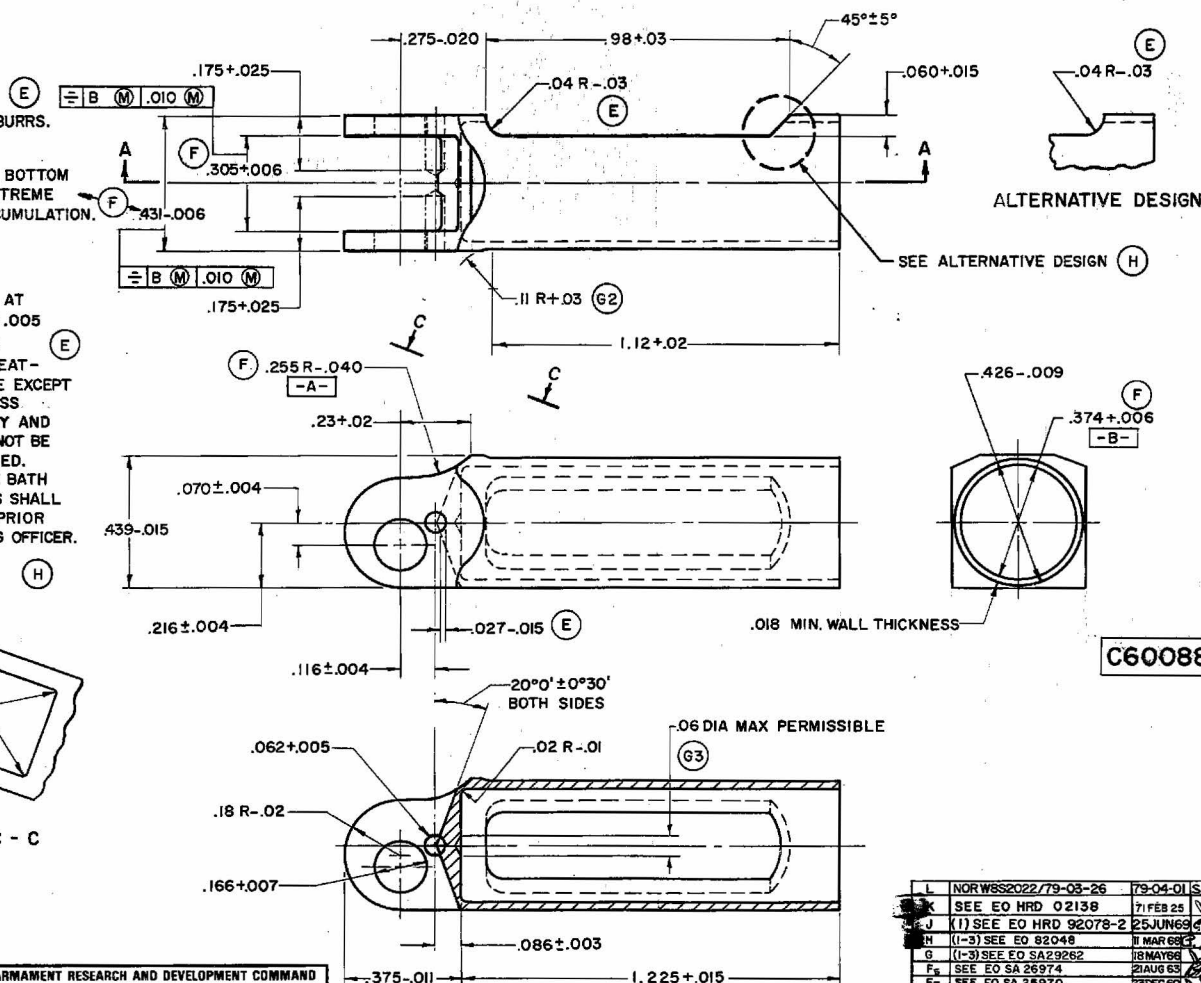
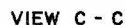
C 6008881

B

A

RMH

1. ALL EDGES SHALL BE FREE OF BURRS.
2. FINISH <sup>125/</sup>
3. RADIUS -A- MAY BREAK INTO BOTTOM  
EDGE OF HOLE -B- AT AN EXTREME  
CONDITION OF TOLERANCE ACCUMULATION.
4. HEAT TREATMENT: CARBURIZE AT  
1550°-1600° F FROM .003 TO .005  
DEPTH. OIL QUENCH TEMPER (E)  
20 MIN AT 350° F. HEAT TREAT-  
MENT METHOD IS FOR GUIDANCE EXCEPT  
THAT CASE DEPTH AND HARDNESS  
REQUIREMENTS ARE MANDATORY AND  
TIME AT TEMPERATURE SHALL NOT BE  
REDUCED BELOW THAT SPECIFIED.  
THE USE OF STRAIGHT CYANIDE BATH  
OR CARBO-NITRIDING PROCESS SHALL  
NOT BE PERMITTED WITHOUT PRIOR  
APPROVAL OF THE CONTRACTING OFFICER.
5. MIL-W-13855 SHALL APPLY.









U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND  
DOVER, NEW JERSEY 07801

19200

FILE NAME:

## FILE HARD

FINISH 5.3.1.2 OF MIL-STD-171

**F F G**

600898

PART NO. 600888

19	ORIGINAL DATE OF TRAINING	2 AUG 37
----	------------------------------	----------

OF DRAWING 2 AUG 57	
DRAFTSMAN H. D. C.	CHECKER <i>OK</i>

TRACER	JL P	CHECKER	OK
--------	------	---------	----

ENGINEER <i>J. L. ...</i>	ENGINEER <i>A. D. ...</i>
---------------------------	---------------------------

SUBMITTED *2.2.1*

R. L. Henry

APPROVED \_\_\_\_\_

APPROVED BY ORDER OF THE  
CHIEF OF ORDNANCE

H. F. Lenz SC

HOUSING,  
HAMMER SPRING

DATE OF THE ORDER

~~U.S. ARMY WEAPONS~~

~~COMMAND~~

ROCK ISLAND, ILL. 6126

\_\_\_\_\_

DWG  
SIZE C000003

6008883

SHEET	1	OF	1
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**P. M. H.**

R. M. H.

\_\_\_\_\_

NOTICE - WHEN GOVERNMENT DRAWINGS SPECIFYING OR OTHER DATA ARE USED FOR ANY PURPOSE OTHER THAN CONNECTION WITH A DEFINITELY RELATED GOVERNMENT PROCUREMENT, THE USER SHALL BE RESPONSIBLE FOR OBTAINING THE NECESSARY PERMISSION FROM THE GOVERNMENT. THE GOVERNMENT MAY HAVE FORNULATED SPECIFICATIONS OR OTHER DATA NOT TO BE REPRODUCED BY REPLICATION OR OTHERWISE AS IN ANY MANNER LITIGATING THE HOLDER OR ANY OTHER PERSON OR CORPORATION OR CONVEYING ANY RIGHTS OR PERMISSION TO MANUFACTURE, USE, OR SELL ANY PATENTED INVENTION THAT MAY IN ANY WAY BE PROTECTED THEREIN.

(M)

WIRE DIAMETER ----- .029 ± .001  
 COIL DIAMETER ( I.D. ) ----- .061 ± .002  
 FREE LENGTH ----- .480 REF  
 TOTAL COILS ----- 12 REF  
 DIRECTION OF HELIX ----- OPTIONAL  
 LOAD AT COMPRESSED LENGTH OF .400 --- 9 LBS MIN  
 LOAD AT COMPRESSED LENGTH OF ----- LB ± LB  
 SPRING RATE ----- 106 LB/IN MIN  
 SOLID LENGTH ----- .350 MAX  
 TYPE OF ENDS ----- CLOSED ENDS GROUND  
 MANUFACTURE IN ACCORDANCE WITH MIL-S-13572, TYPE I, GRADE A.

(K)

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
G		28 JUN 61	
H	REDRAWN AND REVISED SEE ED SA 27441	2 NOV 64	<i>Henry</i>
J	(1) SEE EO SA 29262	18 MAY 66	<i>W.S.</i>
K	(1-2) SEE EO 82048	11 MAR 69	<i>W.S.</i>
L	(1) SEE EO HRD 92078-2	25 JUN 69	<i>W.S.</i>
M	SEE EO HQR 02138	71 FEB 75	<i>W.S.</i>
N	SEE ERR HQR 40681	10 FEB 75	<i>W.S.</i>
P	NOR WBS2022/79-03-26	79-04-01	<i>SA R.H.L.</i>
R	NORW4S2051/840824 ECPW5S2069 / 851223	860121	<i>W.S.</i>

NOTES:

(N)

- HOLE DIA INTO WHICH SPRING FITS FREELY .124 MIN.
- ROD DIA OVER WHICH SPRING SLIDES FREELY MAX.
- HEAT TREATMENT: STRESS RELIEVE AT 425 °F. TO 445 °F. FOR 30 MIN, AFTER COILING.
- STRAIGHTNESS: SPRINGS SHALL BE CAPABLE OF PASSING THRU A .124 DIA HOLE .375 LONG.
- LOAD REQUIREMENT SHALL APPLY AFTER SPRING HAS BEEN COMPRESSED TO SOLID LENGTH 3 TIMES.

(USED WITH PLUNGER 5013671)

CURRENT DESIGN ACTIVITY FSCM NO. 19205  
 U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
 DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES		RIFLE, M14 RIFLE, M14	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	ORIGINAL DATE OF DRAWING 2 AUG 37	DRAFTSMAN J.L. MCS	CHECKER P.M.	PART NO. 6008886
YP	B 6008618	30R-M1, MIC	TOLERANCES ON DECIMALS ± FRACTIONS ±	ENGINEER P.H. Luby	SPRING, HELICAL, COMPRESSION		
TS		8 MID	ANGLES ±	CHECKER W.S.			
EL 2			MATERIAL: STEEL WIRE, SPEC QQ-W-470	ENGINEER P.H. Luby	19205 B 6008886		
RA			HEAT TREATMENT SEE NOTE 3	ENGINEER P.H. Luby			
BH		NEXT ASSY USED ON APPLICATION	FINAL PROTECTIVE FINISH LUB OIL, SPEC VV-L-800	APPROVED <i>W.S.</i>	SCALE UNIT WT SHEET 1 OF 1		
RH		DO NOT APPLY PART NO					

SWESP Form 467  
 6 MAR 63

NOTICE - WHEN GOVERNMENT DRAWINGS SPECIFICATIONS OR OTHER DATA ARE USED FOR ANY PURPOSE OTHER THAN IN CONNECTION WITH A DEFINITELY RELATED GOVERNMENT PROCUREMENT OPERATION THE UNITED STATES GOVERNMENT THEREBY INCURS NO RESPONSIBILITY NOR ANY OBLIGATION WHATSOEVER, AND THE FACT THAT THE GOVERNMENT MAY HAVE FORMULAS OR SPECIFICATIONS OR OTHER DATA IS NOT TO BE REGARDED BY REPLICATION OR OTHERWISE AS IN ANY MANNER LICENSING THE HOLDER OR ANY OTHER PERSON OR CORPORATION OR CONVEYING ANY RIGHTS OR PERMISSION TO MANUFACTURE, USE OR SELL ANY PATENTED INVENTION THAT MAY IN ANY WAY BE RELATED THERETO

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
F		11 OCT 63	
G	REDRAWN AND REVISED SEE EO SA27441	2 NOV 64	<i>R. Henry</i>
H	(1) SEE EO SA 29262	18 MAY 66	<i>R. Henry</i>
J	(1-2) SEE EO 82048	11 MAR 68	<i>R. Henry</i>
K	(1) SEE EO HRD 92078-2	25 JUN 69	<i>R. Henry</i>
L	SEE EO HRD 02138	7 FEB 75	<i>R. Henry</i>
M	(4) SEE ERR HQ 40681	10 FEB 75	<i>R. Henry</i>
N	NOR W662022/75-03-25	75-04-05	<i>R. Henry</i>
P	NORW4S2051/840824 ECPW5S2069 / 851223	860121	<i>R. Henry</i>

WIRE DIAMETER ----- .0625 ± .0005  
 COIL DIAMETER ( O.D. ) ----- .363 ± .005  
 FREE LENGTH ----- 2.15 REF  
 TOTAL COILS ----- 20 REF  
 DIRECTION OF HELIX ----- OPTIONAL  
 LOAD AT COMPRESSED LENGTH OF 1.55 ----- 30 LB ± 3 LB  
 LOAD AT COMPRESSED LENGTH OF 1.3 ----- 42.5 LB ± 3.5 LB  
 SPRING RATE ----- 50 LB/IN REF  
 SOLID LENGTH ----- 1.265 MAX  
 TYPE OF ENDS ----- CLOSED ENDS GROUND W/IN 5°  
 MANUFACTURE IN ACCORDANCE WITH MIL-S-13572, TYPE I, GRADE A.

# NOTES:

1. HOLE DIA INTO WHICH SPRING FITS FREELY .374 MIN.
2. ROD DIA OVER WHICH SPRING SLIDES FREELY .222 MAX.
3. HEAT TREATMENT: STRESS RELIEVE AT 425 °F. TO 445 °F. FOR 30 MIN, AFTER COILING.
4. PITCH IS 8 COILS PER INCH APPROXIMATELY.
5. LOAD REQUIREMENTS SHALL APPLY AFTER SPRING HAS BEEN COMPRESSED TO SOLID LENGTH 3 TIMES.

(USED WITH HOUSING, HAMMER SPRING 6008883)

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
 U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
 DOVER, NEW JERSEY 07801

<div>MECHANICAL PROPERTIES</div> <div>YP</div> <div>TS</div> <div>EL 2</div> <div>RA</div> <div>BH</div> <div>RH</div>		<div>RIFLE, M4 NM</div>		<div>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES</div>		<div>ORIGINAL DATE OF DRAWING 2 AUG 37</div>		<div>SPRING, HELICAL, COMPRESSION</div>	
		<div>D 7790195</div> <div>D 6528297</div>		<div>RIFLE, M4</div> <div>30R-MI, MIC</div> <div>8 MID</div>		<div>TOLERANCES ON DECIMALS ±</div> <div>FRACTIONS ± ANGLES ±</div>			
		<div>NEXT ASSY</div> <div>USED ON</div>		<div>MATERIAL: STEEL, WIRE, MUSIC, ASTM A228</div>		<div>SUBMITTED</div>			
		<div>APPLICATION</div>		<div>HEAT TREATMENT SEE NOTE 3</div>		<div>APPROVED</div>			
		<div>DO NOT APPLY PART NO</div>		<div>FINAL PROTECTIVE FINISH LUB OIL, SPEC VV-L-800</div>		<div>SCALE</div>		<div>UNIT WT</div>	
		<div>AS SPECIFIED</div>				<div>SHEET</div>		<div>OF</div>	



NOTES:

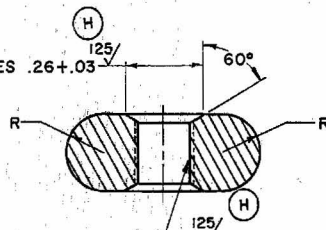
1. FINISH  $25\sqrt{\text{V}}$  EXCEPT AS NOTED.

2. ALL EDGES SHALL BE BROKEN  
.01+.02 UNLESS OTHERWISE  
SPECIFIED.

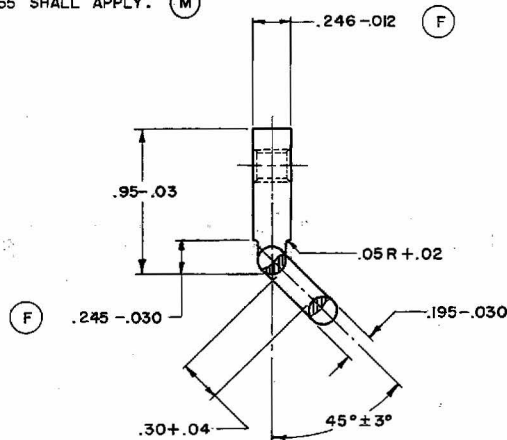
3. MATERIAL: STEEL, SPEC ASTM  
A575, A576, ASTM A108  
1018 THRU 1022 OR SPEC  
QQ-S-637-1141.

4. MIL-W-13855 SHALL APPLY.

C'SINK BOTH SIDES .26+.03

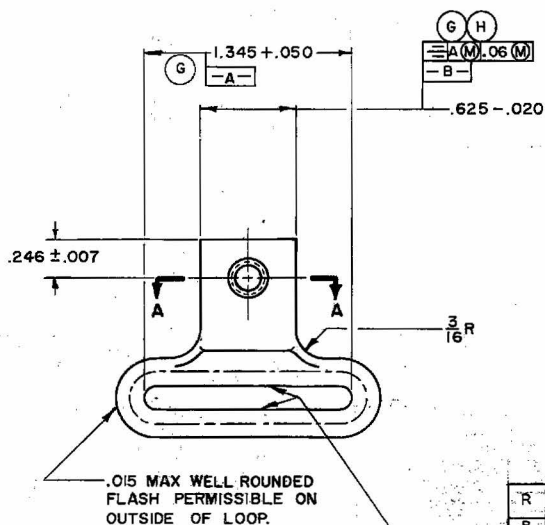


SECTION A-A  
SCALE 4/1



ORIGINAL FSCM NO.19205

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801



INSIDE OF LOOP SHALL BE  
FREE OF FLASH AND SHARP  
EDGES. .06 MAX FLAT  
PERMISSIBLE INSIDE OF LOOP.

R	ECPW552069 / 851223	860121	
P	NORW452051/840824		
N	(3) SEE ERR HQR 4068	10FEB7	
M	SEE EO HRD 02138	71FEB25	
L	(1) SEE EO HRD 92078-2	25JUN63	
K	(2) SEE EO 82048	11MAR68	
J	(1-2) SEE EO SA 29262	18MAY68	
H6	SEE EO SA 27473	25JUN64	
G6	REFED NO. SA 26503	27SEP62	
F	SEE EO SA 26110	4APR61	
E1	SEE EO. SA 25327	1SEP59	
D	REDRAWN AND REVISED	10JUL58	
C	SEE EO SA 24529	21MAR55	
STM		DATE	APPROVAL

PART NO. 6008889

SWIVEL,  
BUTT

6008889

R.M.H.

PHYSICAL PROPERTIES	F1686428	RIFLE, M14
TP	F11010264	.30R, M14
TS	D6535468	MD, RIFLE
EL S	9392337	M14-NM
RA		
SH	NEXT ASSY	USED ON
PR	DO NOT	APPLY PART NO.

TOLERANCES ON DECIMALS	ANGLES ± 1°	FRACTIONS ± .01
MATERIAL	SEE NOTE 3.	
HEAT TREATMENT		
FINAL PROTECTIVE FINISH	FINISH NO. 53.12 OR 53.2.2 OF MIL-STD-171	

ORIGINAL DATE OF DRAWING	2 AUG 37
DRAFTSMAN E.J.R.	CHECKER
TRACER C.F.J.	CHECKER
ENGINEER	ENGINEER
SUBMITTED	
APPROVED BY	
CHIEF OF DESIGN	

SCALE	2/1
UNIT WT.	.05

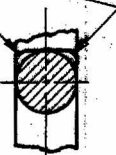
REVISIONS	
DATE	
APPROVAL	

NOTICE - WHEN GOVERNMENT DRAWINGS SPECIFICATIONS OR OTHER DATA ARE USED FOR ANY PURPOSE OTHER THAN IN CONNECTION WITH A SPECIFICALLY RELATED GOVERNMENT PROCUREMENT OR OPERATION OF THE UNITED STATES GOVERNMENT, THE USER INCURS NO RESPONSIBILITY FOR ANY OBLIGATION, WARRANTY, OR LIABILITY. THE UNITED STATES GOVERNMENT MAY HAVE FORMULATED, PROVIDED, OR OTHERWISE SUPPLIED THE SAID DRAWINGS SPECIFICATIONS OR OTHER DATA, BUT IT IS NOT TO BE REGARDED BY THE USER OR ANY OTHER PERSON OR CORPORATION OR COMPANY OR ANY RIGHTS OR PERMISSION OF MANUFACTURE, USE, OR SALE OF THE DRAWING OR SPECIFICATION THAT MAY IN ANY WAY BE RELATED THERE-TO.

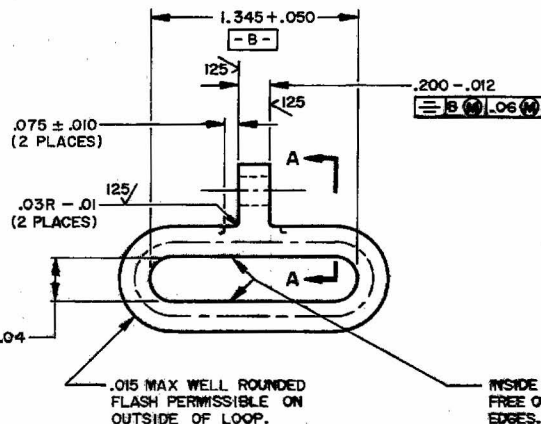
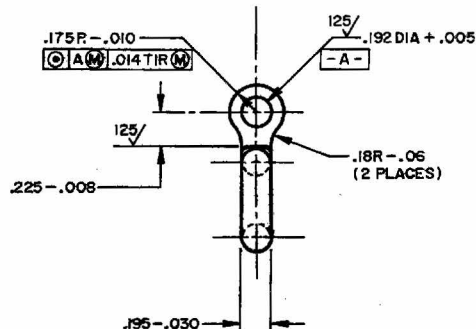
# NOTES:

1. FINISH  $250\sqrt{\phantom{x}}$  EXCEPT AS NOTED.
2. ALL EDGES SHALL BE BROKEN  $.01 + .02$  UNLESS OTHERWISE SPECIFIED.
3. MATERIAL: STEEL, CARBON  $1018$  (H1) SAE 1018 THRU 1022, 1141; ASTM A108
4. MIL-W-13855 APPLIES.

$.005R + .045$



PARTIAL SECTION AA  
SCALE: 4/1



REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
F		5 MAY 60	
G	REDRAWN AND REVISED SEE EO SA 27411	16 MAY 64	
H	(1) SEE EO SA 29263	16 MAY 66	
J	(1) SEE EO SA 29615	23 AUG 66	
K	SEE ERR NGR 40683	12 NOV 74	
L	NOR WAS2051/840824	860121 NR	

CURRENT DESIGN ACTIVITY FSCN NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

PART NO. 6008890

C5564073		30 BAR-M1982				
B11010044		RIFLE, M14A1				
MECHANICAL PROPERTIES	D6535467	.30R-M1, MIC & MID	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	ORIGINAL DATE OF DRAWING	2 AUG 37	SPRINGFIELD ARMOY U.S. ARMY WEAPONS COMMAND
YP			TOLERANCES ON DECIMALS ±	DRAFTSMAN	RWD	PRH
TS			FRACTIONS ±	CHECKER	WHS	DSK
EL 2			ANGLES ±	ENGINEER	WHS	DSK
RA	SEE ENGINEERING RECORDS		MATERIAL	SUBMITTER	WHS	DSK
BH	NEXT ASSY USED ON		HEAT TREATMENT	APPROVED	WHS	DSK
RH	APPLICATION		FINAL PROTECTIVE FINISH		WHS	DSK
	DO NOT APPLY PART NO		FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171		WHS	DSK

CODE IDENT NO.	19205	DWG SIZE	C	PART NO.	6008890
SCALE	2/1	UNIT WT.	.03	SHEET	1 OF 1

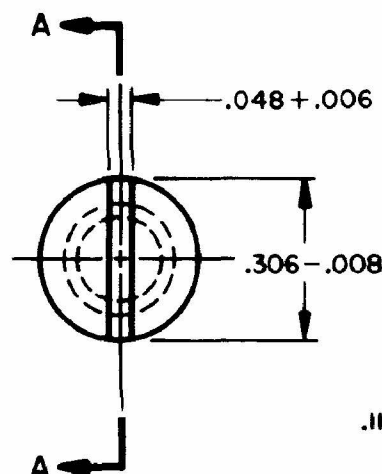
# NOTES:

1. FINISH 125/
2. MATERIAL: STEEL, CARBON, SAE 1018, 1020, 1117; ASTM A108
3. HEAT TREATMENT: CARBURIZE AT 1550° TO 1600°F FROM .003 TO .005 DEPTH. OIL QUENCH. TEMPER 20 MINUTES AT 350°F. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
4. MIL-W-13835 APPLIES.
5. FILEHARD TEST PER NOTE 4.

(H1)

1.0 R MIN  
(BOTTOM OF SLOT  
MAY BE FLAT)

PARTIAL SECTION A-A



(H2)

ORIGINAL DESIGN ACTIVITY FSCM NO. 19205

ORIGINAL DATE OF DRAWING 15 MAR 35

DRAFTSMAN JSK CHECKER DFM

TRACER 939 CHECKER

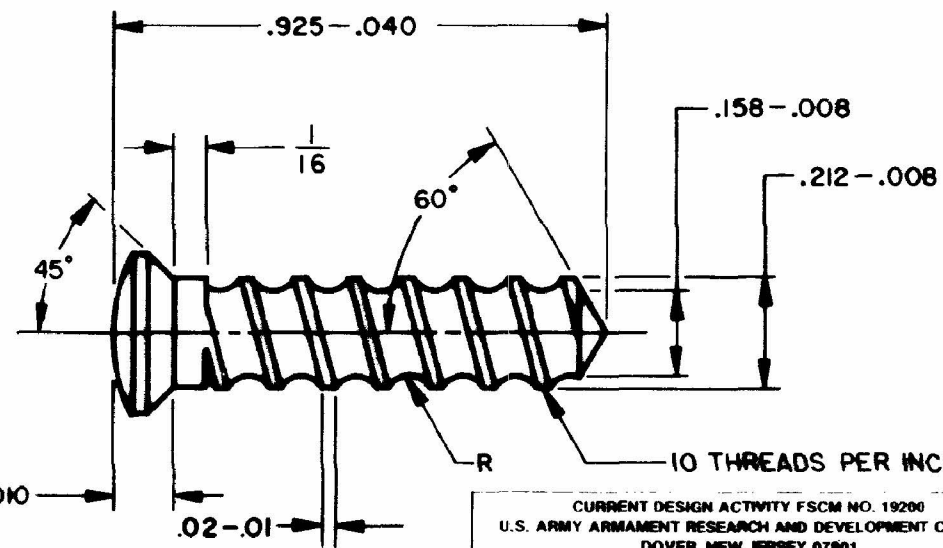
ENGINEER M. Angelini ENGINEER

SUBMITTED

APPROVED

R. L. Henry

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
F		26 AUG 60	
G	REDRAWN AND REVISED		
	SEE EO SA 27232	27 NOV 63	
H	(1-2) SEE EO SA 29263	18 MAY 66	
J	SEE ERR HQR 30644	8 MAR 73	
K	NOR W452051/840824	8 MAR 73	MR



PART NO. 6146873

DEPT OF THE ARMY  
ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201

SCREW, WOOD, SLOTTED  
OVAL HEAD, 90°

CODE IDENT NO.	DWG SIZE	
19204	B	6146873
SCALE 4/1	UNIT WT	SHEET 1 OF 1

F11686528	RIFLE, M14 E2
D7792767	LAUNCHER, M79
42-49-4	.30 M '03 -A4
F 7265697	CBN CAL.30M3
F 7265696	CBN CAL.30M2
F 6544066	CBN CAL.30

MECHANICAL PROPERTIES		MIAI
YP		F 7265694 CBN CAL.30M1
TS		D6535468 .30R-MI, MICBMD
EL 2		C11686409 SHOTGUN, 12GA,
RA		RIOT TYPE
BH		HEAT TREATMENT USED ON
RH		APPLICATION
SEE NOTE 5		DO NOT APPLY PART NO

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES

TOLERANCES ON DECIMALS ±  
FRACTIONS ± 1/64 ANGLES ± 1°

MATERIAL SEE NOTE 2

HEAT TREATMENT SEE NOTE 3

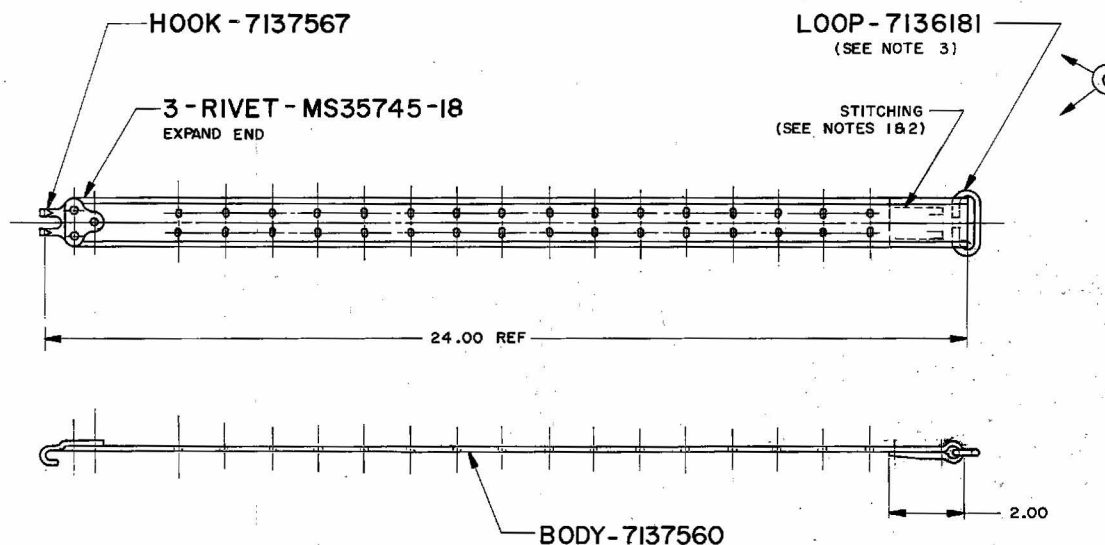
FINAL PROTECTIVE FINISH  
FINISH 5.3.1.2 OR 5.3.2.2 OF  
MIL-STD-171

NOTES:

1. THREAD, POLYESTER, TYPE I, CLASS I, NO. 4, SUBCLASS C (WAXED), COLOR TAN, SHADE X, CA 66041, SPEC V-T-285.
2. STITCHING: STITCH TYPE 301, SEAM TYPE LS<sub>a</sub>-2 PER FED-STD-751, 7 STITCHES PER INCH. STITCHES SHALL BE TIGHT AND ENDS OF THREADS SHALL BE BACKSTITCHED TO PREVENT RAVELING.
3. OPEN SIDE OF LOOP SHALL BE ENCLOSED WITHIN THE STITCHED LOOP OF THE STRAP.
4. MIL-W-13855 APPLIES.

(E)

REVISIONS					
NO.	ZONE	LTR	DESCRIPTION	DATE	APPROVED
B			REDRAWN & REVISED W/CHANGE	14 MAR 68	R. Heberle
			SEE EO-82025		
C			(1-3) SEE EO HRD 92086	25 JUN 69	R. Heberle
D			SEE ERR HQR 10754	11 NOV 71	R. Heberle
E			SEE NOR 75E0025-0001	31 OCT 75	R. Heberle
F			NOR W4S2051 / 840824 (ECP WSS2014 / 790608) (ECP WSS2059 / 851223)	860121	MR



CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 7122387

PART NO. 7122387

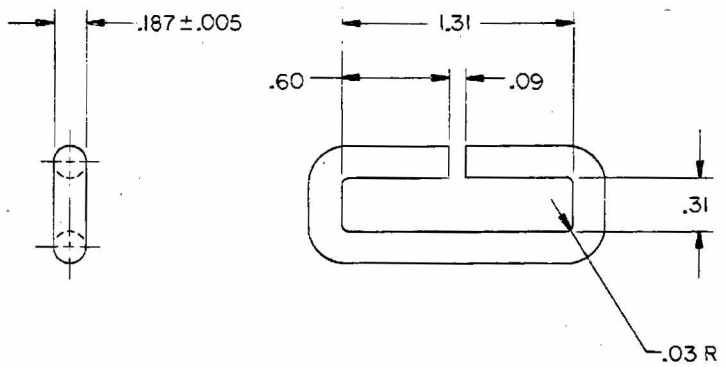
MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 30 MAR 1945		DEPT OF THE ARMY	
YP		TOLERANCES ON DECIMALS	XXX ± .06	DRAFTSMAN	SLG	CHECKER	EWB
TS		ANGLES	XXX ±	YOUNG			
EL 2		MATERIAL		ENGINEER	R. Heberle		
RA		HEAT TREATMENT		SUBMITTED	Philip E. Heberle		
BH	C 7141245	SLING, SMALL ARMS, M1907		APPROVED	R. L. Henry		
RH		NEXT ASSY. USED ON		FINAL PROTECTIVE FINISH			
APPLICATION							

DWG SIZE		CODE IDENT NO.	
C	19204	7122387	
SCALE 1/2	UNIT WT	SHEET 1 OF 1	

NOTES:

- 1. MATERIAL:  
STEEL, CMPSN 1010, ASTM A675 OR  
ASTM A108 OR WIRE, STEEL, CMPSN  
1008, 1010 OR 1012, ASTM A545 OR  
A549.
- 2. FINAL PROTECTIVE FINISH: FINISH  
5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.
- 3. MIL-W-13855 APPLIES.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
K	REDRAWN WITH CHANGE NOR G7S3I24/87O8I8	880916	CRIVZ PVA



CURRENT DESIGN ACTIVITY CAGE CODE 19200  
U.S. ARMY  
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER  
PICATINNY ARSENAL, NEW JERSEY 07806-5000

PART NO. 7136181

SPRINGFIELD ARMORY, SPRINGFIELD, MA

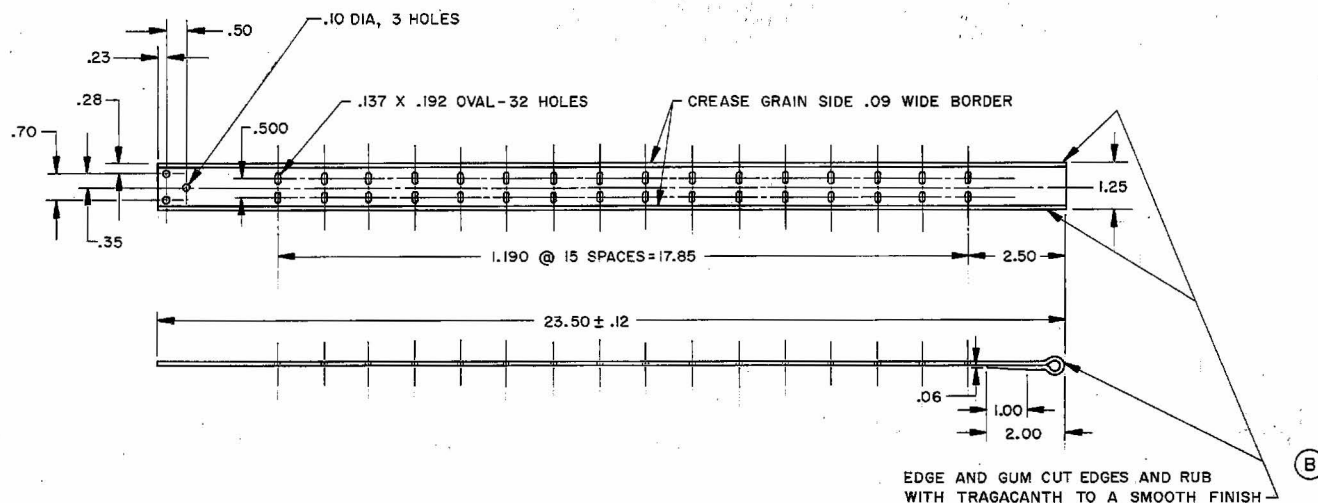
LOOP

		MECHANICAL PROPERTIES		DO NOT SCALE DRAWING		ORIGINAL DATE OF DRAWING		7 SEP 48		SPRINGFIELD ARMORY, SPRINGFIELD, MA	
				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAFTSMAN		CHECKER			
		YP		TOLERANCES ON DECIMALS ±.02		EG		SF			
		TS		FRACTIONS * ANGLES *		ENGR		ENGR			
		EL2		THIRD ANGLE PROJECTION		RP		ENGR			
		RA				ENGR		ENGR			
		BH									
		RH									
105 MM HOW.						SUBMITTED		H.W. JOHNSON		SIZE	
K12000773 COVER OVERALL						APPROVED		T.G. LORESSGEN, JR.		C 19205	
NEXT ASSY		USED ON								7136181	
APPLICATION										SCALE 2/1 UNIT WT.	
										SHEET 1 OF 1	

NOTES:

1. MATERIAL:  
LEATHER, STRAP, TYPE III, CLASS I,  
RUSSET, 8/64 THICK, SPEC-KK-L-271.
2. MIL-W-13855 APPLIES.

REVISIONS				
NO	ZONE	LTR	DESCRIPTION	DATE
A			REDRAWN & REVISED W/CHG	14 MAR 68
B			SEE EO 82025	28 JUN 69
C			(1-2) SEE EO WRD 92086	11 NOV 71
D			SEE ERR HQR 10754	31 OCT 75
E			SEE NOR 75E0025-0004	850#21
			NGR W4S2051/840824 (ECP W9S2014 / 790608) (ECP W5S2063 / 851228)	



CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

PART NO. 7137560

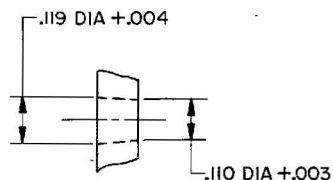
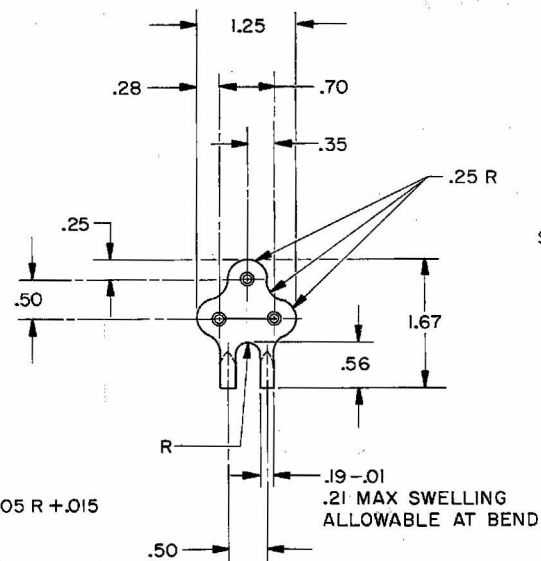
MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 20 NOV, 1950		DEPT OF THE ARMY ROCK ISLAND ARSENAL ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON	DECIMALS XX ± .03 XXX ± .010	DRAFTSMAN	JRC	CHECKER	AWR
TS		ANGLES ±		TRACER	A. S. Gankill	CHECKER	J. P. Reddy
EL 2		MATERIAL	SEE NOTE 1	ENGINEER	F. P. Smith	CHECKER	B. Heberle
RA		HEAT TREATMENT		SUBMITTED	Philip E. Heberle		
BH	C7122387	SLING, SMALL		APPROVED	R. S. Henry		
RH		ARMS, M1907					
	NEXT ASSY.	USED ON	FINAL PROTECTIVE FINISH				
	APPLICATION						
DWG SIZE		CODE IDENT NO.		DWG SIZE		CODE IDENT NO.	
C		19204		C		19204	
SCALE 1/2		UNIT WT		SHEET 1		OF 1	

NOTES:

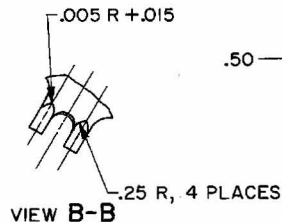
1. MATERIAL:  
STEEL, ASTM A109.
2. BREAK EDGES .015 +.015.
3. FINAL PROTECTIVE FINISH:  
FINISH 5.3.1.2 OR 5.3.2.2  
OF MIL-STD-171.
4. MIL-W-13855 APPLIES.

(E)

REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
			REDRAWN WITH CHANGE	25 JUN 69
			SEE EO HRD 92086	
			SEE ERR HQR 10754	11 NOV 71
			SEE NOR 75E0025-0005	31 OCT 75
			NOR W452051/840824 (ECP W952014/790608)	860121
			(ECP W552069/851223)	
			MR	



VIEW A  
SCALE 5/1



VIEW B-B

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

PART NO. 7137567

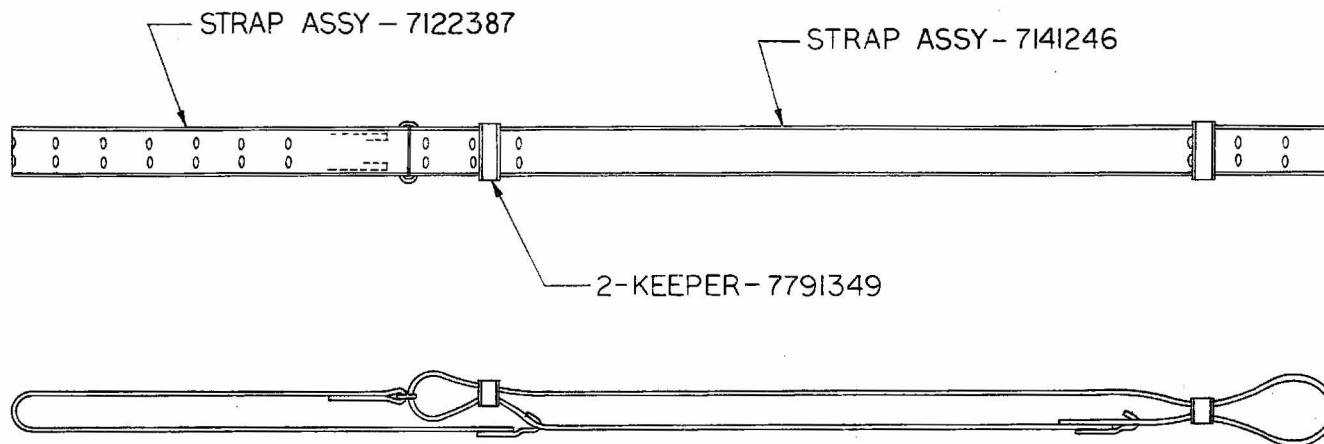
MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 20 NOV 50		DEPT OF THE ARMY ROCK ISLAND ARSENAL ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON DECIMALS .01		DRAFTSMAN	CHECKER	HOOK, GUNSLING	
TS		ANGLES ± XXX ±		DRGSMAN	CHECKER		
EL 2		MATERIAL		DRGSMAN	CHECKER		
RA	C7122387	SLING, SMALL		DRGSMAN	CHECKER		
BH	C7141246	ARMS, M1907		ENGINEER	ENGINEER	DWG SIZE CODE IDENT NO. C 19204 7137567	
RH		HEAT TREATMENT		ENGINEER	ENGINEER		
APPLICATION		FINAL PROTECTIVE FINISH		APPROVED		SCALE 1/1 UNIT WT SHEET 1 OF 1	
		SEE NOTE 3		THOMAS G. SPRINGER			



NOTES:

I. MIL-W-13855 APPLIES.

REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		E	REPLACES REV D W CHANGE SEE NOR 75E0025-0000	31 OCT 75	RE
		F	NOR W4S2041 / 840824 (ECP W5S2014 / 790608) (ECP W5S2063 / 851223)	860121	MR



CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

SEE EPL-7141245

PART NO. 7141245

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING	20 NOV 50	DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON	DECIMALS	DESIGNED BY	8/1/50	SLING, SMALL ARMS, MI907	
TS		ANGLES ±	XXX ±	CHECKED BY	8/1/50		
EL 2		MATERIAL		ENGINEER			
RA		HEAT TREATMENT		SUBMITTED			
BH	J 7790485	RIFLE, M14 (M)		APPROVED	RE. Kipling	DWG SIZE	CODE IDENT NO.
RH	J 9386974	RIFLE, M14 NM		APPROVED	D. D. Cole	C	19204
APPLICATION		FINAL PROTECTIVE FINISH				SCALE 1/2	UNIT WT —
						SHEET 1 OF 1	

NOTE:  
1. STENCIL WITH BLACK INK, TYPE II,  
SPEC TT-I-1795, INDICATING  
MONTH AND YEAR OF TREATMENT.  
2. MIL-W-13855 APPLIES.

6 NOR W4S2057/840824  
(ECP W9S2014/790608)  
(ECP W5S2069/851223)

860121

MR

REVISIONS			
MF	ZONE	LTR	DESCRIPTION
			DATE
			APPROVED
		A	REDRAWN & REVISED W/CHG
			SEE EO 82025
		B	(1-3) SEE EO HRD 92086
			25 JUN 69
		C	SEE ERR HQR 10754
			11 NOV 71
		D	(1) SEE ERR HQR 40681
			10 FEB 75
		E	SEE NOR 75E0025-0007
			31 OCT 75
		F	NOR W9S0032 79-08-22
			79-12-07

HOOK-7137567

3-RIVET-MS35745-18  
EXPAND END

SEE NOTE

21.00 APPROX

.38

.25

.12

.25

DATE

BODY-7141247

47.00 REF

CURRENT DESIGN ACTIVITY FSCM NO.19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST-7141246

PART NO. 7141246

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 15 NOV, 1950	
YP		TOLERANCES ON DECIMALS .XX ± .03 XXX ±		DRAFTSMAN JRC	CHECKER AWR
TS		ANGLES ±		TRACES A. S. Garb. J. P. Rodgers	EXCHG
EL 2		MATERIAL		ENGINEER Philip E. Heberle	EXCHG
RA		HEAT TREATMENT		SUBMITTED	
BH	C 7141245	SLING, SMALL	APPROVED R. S. Henry		
RH		ARMS, M1907	FINAL PROTECTIVE FINISH		
NEXT ASSY.		USED ON		DWG SIZE C	
APPLICATION				CODE IDENT NO. 1820	
				7141246	
				SCALE 1/2	
				UNIT WT	
				SHEET 1 OF 1	

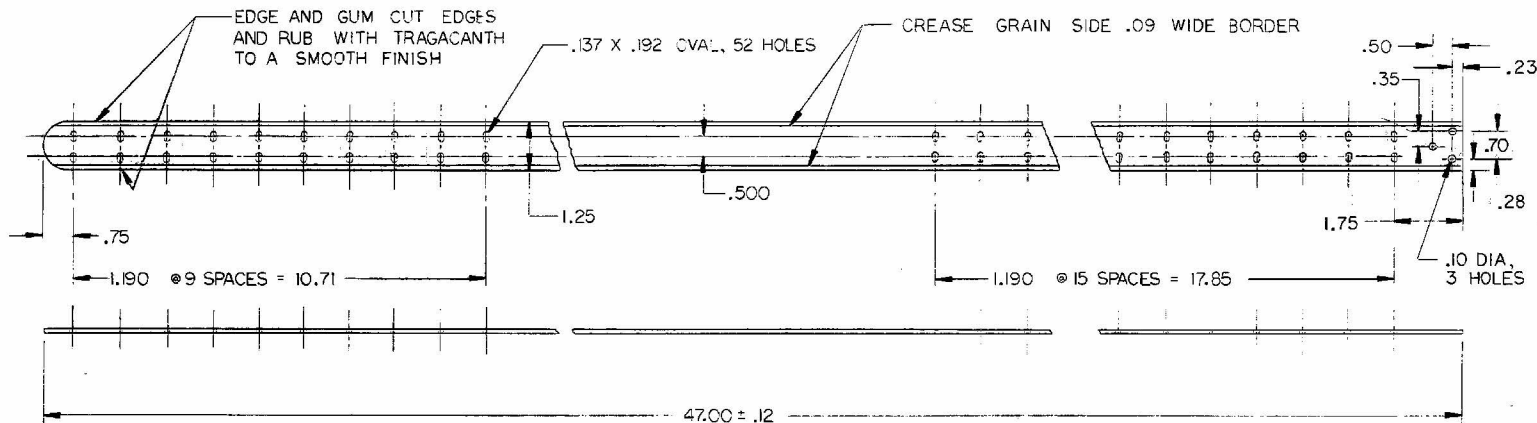
DRAWING SIZE C  
(ARRADCOMR 70-12)

NOTES:-

1- LEATHER, STRAP, TYPE III,  
CLASS 1, RUSSET, 8/64 THICK,  
SPEC KK-L - 271.

2- MIL-W-13855 APPLIES.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
E	REPLACES REV D W/CHANGE NOR W9S0032 79-08-22	79-12-07	R.A. All
F	NOR W4S2031/840824 (ECP W9S2014/790603) (ECP W5S2069/851223)	860121	M.P. E.M.



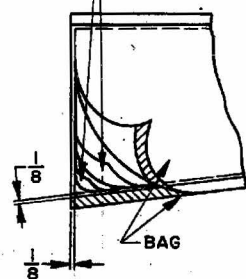
ORIGINAL DESIGN ACTIVITY FSCM NO. 19204

PART NO. 7141247

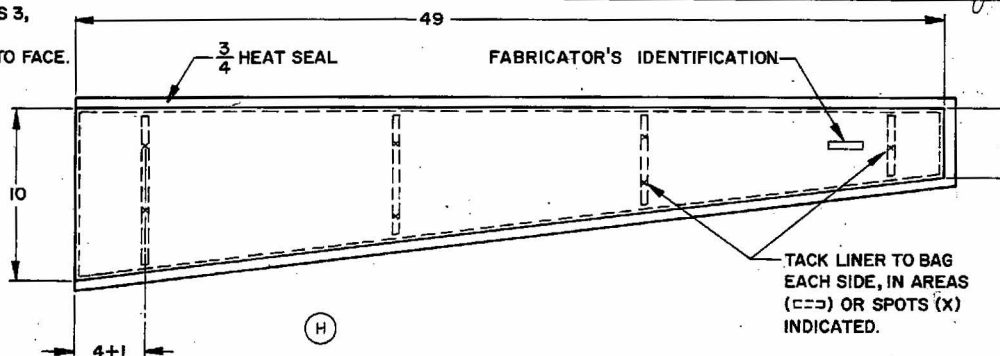
C 7141246 SLING, SMALL ARMS, M1907 NEXT ASSY USED ON APPLICATION		MECHANICAL PROPERTIES		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ± .03 FRACTIONS ± ANGLES ± .010 MATERIAL SEE NOTE 1	ORIGINAL DATE OF DRAWING 20 NOV 1950		U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801	
		YP			DRAFTSMAN	CHECKER	BODY, STRAP, LONG	
		TS			JRC	AWR		
		EL2			ENGR	ENGR		
		RA			ER RANDOLPH	GL RANDAZZA		
		BH			ENGR	ENGR		
		RH			UP SMITH	HEBERLE		
					PHILIP E. HEBERLE			
					R. S. HENRY			
					SIZE	FSCM NO	7141247	
					C	19200		
					SCALE 1/2		UNIT WT.	SHEET 1 OF 1

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
E		25 MAR 63	
F	REDRAWN & REVISED SEE EO SA 27456	15 MAY 64	<i>R. K. ...</i>
G	SEE EO SA 28002	27 MAY 65	<i>R. K. ...</i>
H	SEE EO SA 28723	16 DEC 65	<i>R. K. ...</i>
J	(1-2) SEE EO 84044	3 JUNE 68	<i>R. K. ...</i>
K	SEE EO HRD 04087	10 SEPT 70	<i>R. K. ...</i>
L	SEE HQP-31608	1 FEB 73	<i>R. K. ...</i>

LINER CONFORMING TO  
STYLE A, TYPE I, CLASS 3,  
OF MIL-P-3420.  
TREATED SIDES FACE TO FACE.



VIEW SHOWING  
CONSTRUCTION



MECHANICAL PROPERTIES YP TS EL 2 RA BH RH		RIOT TYPE 12 GAGE, AND SHOTGUNS	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ± FRACTIONS ± 1/8 ANGLES ± MATERIAL: SPEC MIL-B-40028 HEAT TREATMENT FINAL PROTECTIVE FINISH	ORIGINAL DATE OF DRAWING 27 NOV 51 DRAFTSMAN TRACER ENGINEER SUBMITTED APPROVED	DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201 BAG, BARRIER, W/ VCI TREATED LINER (FOR RIFLES AND SHOTGUNS) CODE IDENT NO. DWG SIZE 19204 B 7265933 SCALE 1/5 UNIT WT SHEET OF 1
		CAL .22 RIFLES ALL CAL .308 7.62 MM RIFLES D8449427 PACKAGING OF SEE ENGINEERING RECORDS NEXT ASSY USED ON APPLICATION DO NOT APPLY PART NO AS SPECIFIED		(J1) (H) (G) PART NO. 7265933 (J2)	

SWESP. 1176-1  
28 AUG 62

PDC

DC FORM 1181-3  
9 AUG 48  
ORDIN

PHYSICAL PROPERTIES		APPLICATION		A7266316		
YP		NEXT ASSY	USED ON	REVISIONS		
TS		SEE ENGINEERING RECORDS				
EL 2		CAL 30 8 762	SYM	DESCRIPTION	DATE	APPROVAL
RA		MM. FILES		INITIAL RELEASE REF EC NO.		
BH		8 MACHINS.		SA 2424B		
RH		PACKA	A	REF EC NO. SA 24587	6MAY58	
		DO NOT	APPLY PART NO.			
		DO	AS SPECIFIED			

NOTE: - WHEN GOVERNMENT DRAWING SPECIFICATIONS, OR OTHER DATA, ARE USED FOR ANY PART OF A DRAWING, THE DRAWING IS NOT TO BE CONSIDERED A GOVERNMENT DRAWING UNTIL THE GOVERNMENT HAS REVIEWED AND APPROVED THE DRAWING. THE GOVERNMENT IS NOT RESPONSIBLE FOR THE ACCURACY OF ANY DATA OR OTHER DATA IN THIS DRAWING. THE GOVERNMENT IS NOT RESPONSIBLE FOR THE ACCURACY OF ANY DATA OR OTHER DATA IN THIS DRAWING. THE GOVERNMENT IS NOT RESPONSIBLE FOR THE ACCURACY OF ANY DATA OR OTHER DATA IN THIS DRAWING.

(A)

SEE DRAWING B7266299 FOR  
DESCRIPTION OF THIS PART

ORD PART NO. 7266316

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON-		ORIGINAL DATE OF DRAWING 17 JUN 1957	TUBE, BORE, VCI TREATED	SPRINGFIELD ARMORY ORDNANCE CORPS DEPT OF THE ARMY SPRINGFIELD 1, MASS.
DECIMALS	DRAFTSMAN	CHECKER		
FRACTIONS	TRACER	CHECKER		
ANGLES	ENGINEER	ENGINEER		
MATERIAL	SUBMITTED			
HEAT TREATMENT				
FINAL PROTECTIVE FINISH				

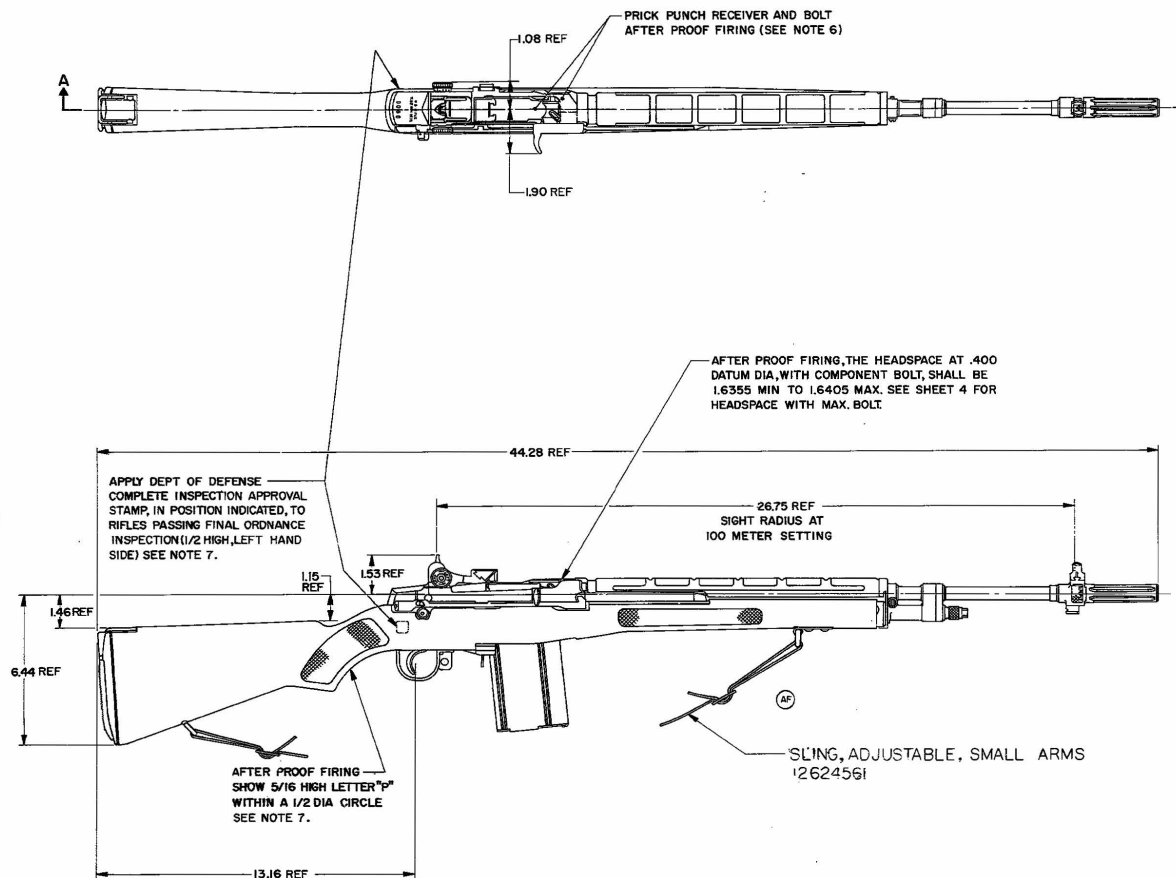
DWG  
SIZE  
A

7266316

SHEET 1 of 1

NOTES:

1. EACH RIFLE SHALL WITHSTAND THE FIRING OF ONE GOV'T STANDARD HIGH PRESSURE TEST CARTRIDGE WITHOUT EVIDENCE OF FAILURE. APPLY PROOF MARK AS INDICATED TO RIFLES MEETING THIS REQUIREMENT.
2. FOR APPLICATION OF SERIAL NO. MANUFACTURER'S IDENTIFICATION AND IDENTIFICATION MARKINGS OF U.S. MILITARY PROPERTY SEE DWG F7790189.
3. EITHER GAGE C7271723 OR C7271724 SHALL ENTER THE MUZZLE UP TO THE HANDLE OF THE GAGE AND THE .329 DIA OF THE GAGE SHALL NOT TOUCH THE FLASH SUPPRESSOR. GAGE C7271723 SHALL BE USED WHEN THE BORE DIA IS .3005 OR SMALLER. GAGE C7271724 SHALL BE USED WHEN THE BORE DIA IS .3006 OR LARGER.
4. PREFERENTIAL ASSEMBLY OF BARREL AND RECEIVER PERMISSIBLE TO MEET HEADSPACE REQUIREMENTS (SEE SHEET 4) WITHOUT SUBSEQUENT HEADSPACE MACHINING.
5. AFTER COMPLETION OF ALL FIRING TESTS (HIGH PRESSURE RESISTANCE, FUNCTION FIRING, AND TARGETING AND ACCURACY) PER MIL-R-45012, EACH BOLT AND ROLLER ASSEMBLY C7790186 SHALL BE FREE OF EVIDENCE OF FAILURE AS DETERMINED BY MAGNETIC PARTICLE INSPECTION FOR CRACKS, SEAMS AND OTHER INJURIOUS DEFECTS, IN ACCORDANCE WITH METHOD SPECIFIED ON DWG C7790186. APPLY MPI MARK TO ASSY, AS SHOWN ON C7790186, MEETING THIS REQUIREMENT. AFTER CLEANING THE ASSY, THE ROLLER SHALL BE REPACKED WITH GREASE CONFORMING TO MIL-G-10924.
6. USE RUBBER STAMP WITH WHITE INK FED SPEC TT-1-558 CONFORMING TO COLOR NO. (37875) OF FED. STD. NO. 595.
7. MIL-R-45012 SHALL APPLY.
8. FOR INFORMATION ONLY: SUPPORT EQUIPMENT IS LISTED ON DWG A12002927. SUPPORT EQUIPMENT IS NOT PACKAGED OR INCLUDED WITH THE RIFLE.
9. MIL-W-13855 SHALL APPLY.



REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
1B	REDRAWN WITH CHANGE WAS "D" SIZE.	21 JUN 68	W. J. R.
1C	SEE EO NO. 54 23335	3 OCT 68	W. J. R.
1D	SEE EO NO. 54 23335	11 MAR 68	W. J. R.
1E	SEE EO MID 02187	28 JUL 70	W. J. R.
1F	SEE EO NOR 30617	22 JAN 73	W. J. R.
1G	SEE EO NOR 30617	22 JAN 73	W. J. R.
1H	SEE EO NOR 30617	22 JAN 73	W. J. R.
1I	SEE EO NOR 30617	22 JAN 73	W. J. R.
1J	SEE EO NOR 30617	22 JAN 73	W. J. R.
1K	SEE EO NOR 30617	22 JAN 73	W. J. R.
1L	SEE EO NOR 30617	22 JAN 73	W. J. R.
1M	SEE EO NOR 30617	22 JAN 73	W. J. R.
1N	SEE EO NOR 30617	22 JAN 73	W. J. R.
1O	SEE EO NOR 30617	22 JAN 73	W. J. R.
1P	SEE EO NOR 30617	22 JAN 73	W. J. R.
1Q	SEE EO NOR 30617	22 JAN 73	W. J. R.
1R	SEE EO NOR 30617	22 JAN 73	W. J. R.
1S	SEE EO NOR 30617	22 JAN 73	W. J. R.
1T	SEE EO NOR 30617	22 JAN 73	W. J. R.
1U	SEE EO NOR 30617	22 JAN 73	W. J. R.
1V	SEE EO NOR 30617	22 JAN 73	W. J. R.
1W	SEE EO NOR 30617	22 JAN 73	W. J. R.
1X	SEE EO NOR 30617	22 JAN 73	W. J. R.
1Y	SEE EO NOR 30617	22 JAN 73	W. J. R.
1Z	SEE EO NOR 30617	22 JAN 73	W. J. R.

REV	DESCRIPTION	DATE	APPROVED
1B	REDRAWN WITH CHANGE WAS "D" SIZE.	21 JUN 68	W. J. R.
1C	SEE EO NO. 54 23335	3 OCT 68	W. J. R.
1D	SEE EO NO. 54 23335	11 MAR 68	W. J. R.
1E	SEE EO MID 02187	28 JUL 70	W. J. R.
1F	SEE EO NOR 30617	22 JAN 73	W. J. R.
1G	SEE EO NOR 30617	22 JAN 73	W. J. R.
1H	SEE EO NOR 30617	22 JAN 73	W. J. R.
1I	SEE EO NOR 30617	22 JAN 73	W. J. R.
1J	SEE EO NOR 30617	22 JAN 73	W. J. R.
1K	SEE EO NOR 30617	22 JAN 73	W. J. R.
1L	SEE EO NOR 30617	22 JAN 73	W. J. R.
1M	SEE EO NOR 30617	22 JAN 73	W. J. R.
1N	SEE EO NOR 30617	22 JAN 73	W. J. R.
1O	SEE EO NOR 30617	22 JAN 73	W. J. R.
1P	SEE EO NOR 30617	22 JAN 73	W. J. R.
1Q	SEE EO NOR 30617	22 JAN 73	W. J. R.
1R	SEE EO NOR 30617	22 JAN 73	W. J. R.
1S	SEE EO NOR 30617	22 JAN 73	W. J. R.
1T	SEE EO NOR 30617	22 JAN 73	W. J. R.
1U	SEE EO NOR 30617	22 JAN 73	W. J. R.
1V	SEE EO NOR 30617	22 JAN 73	W. J. R.
1W	SEE EO NOR 30617	22 JAN 73	W. J. R.
1X	SEE EO NOR 30617	22 JAN 73	W. J. R.
1Y	SEE EO NOR 30617	22 JAN 73	W. J. R.
1Z	SEE EO NOR 30617	22 JAN 73	W. J. R.

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PART NO. 7267000 FSCM NO. 19200

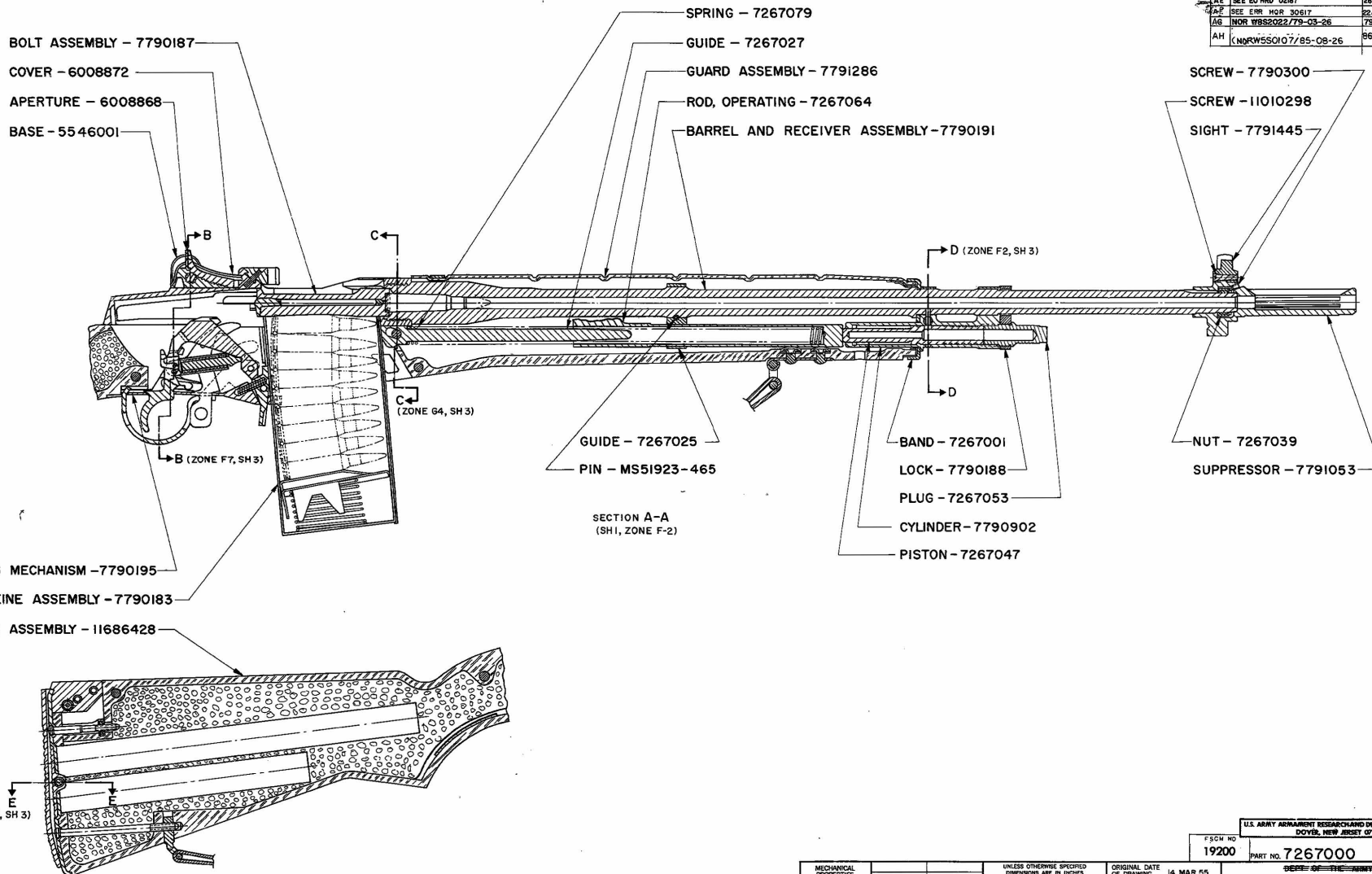
FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 7267000

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 14 MAR 68	
TP		TOLERANCES ON DIMENSIONS		DESIGNED BY AUA	CHECKED BY J.R.K.
TS		FRACTIONS		TRACED BY AUA	CHECKED BY J.R.K.
EL 2		ANGLES		MATERIAL	
RA				HEAT TREATMENT	
BH				FINAL PROTECTIVE FINISH	
SH					
NEXT ASSY USED ON		APPLICATION		APPROVED	
		APPLY MARKINGS PER MIL-STD-130 AS SPECIFIED.		Robert S. Henry	
				D. A. Lusk	

RIFLE, 7.62 MM, M14

ENG SIZE F 19200 SCALE 1/2 UNIT WT SHEET 1 OF 4

NOTE: MIL-W-13855 SHALL APPLY.



REVISIONS			
LTN	DESCRIPTION	DATE	APPROVED
AB	REDRAWN WITH CHANGE, WAS 1/2" DIA.	21 JUN 68	1/1/68
AC	SEE EO NO. 34-2390	5 OCT 66	
AD	SEE EO NO. 34-2394	11 MAR 68	
AE	SEE EO MRO 02187	28 JUL 70	
AF	SEE ERM MGR 30617	22 JAN 73	
AG	INCR WBS022/79-03-26	79-04-01	
AH	(NORW550107/85-08-26	86 01 24	2/1/86

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 14 MAR 55	
TP		TOLERANCES ON DECIMALS IN		DRAWNMAN AVA	CHECKER JPK
TS		FRACTIONS IN		TRACER 1/16-24	CHECKER 1/16-24
EL 2		ANGLES IN		ENGINEER 1/16-24	CHECKER 1/16-24
RA				SUBMITTED	
BH		HEAT TREATMENT			
RH		FINAL PROTECTIVE FINISH			
NEXT ASBY USED ON		APPLICATION		APPROVED	
				1/1/68	

U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801	
FSCM NO 19200	PART NO. 7267000 (AD)
RIFLE, 7.62 MM, M14	
ORG SIZE F	7267000
SCALE 1/1	SHEET 2 OF 4

NOTE: MIL-W-13855 SHALL APPLY.

PINION ASSY-11010363

KNOB ASSY-7312737

PIN-MS16562-124  
OR MS51923-422

STOP-7267034

SPRING-7267074

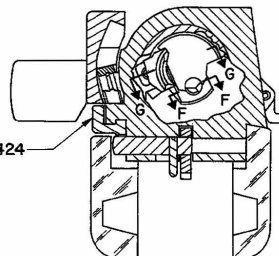
SECTION B-B  
(SH 2 ZONE F-7)

CONNECTOR ASSY-7790424



PARTIAL SECTION OF  
CONNECTOR ASSEMBLY

SECTION C-C  
(SH 2 ZONE F-6)

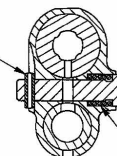


PIN-MS16562-107  
OR MS51923-272

VALVE-7267604

SPRING-7267605

SECTION D-D  
(SH 2 ZONE F-3)

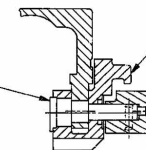


SHAFT-7267072

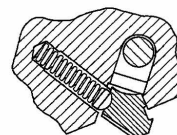
RELEASE-7790192

LOCK-7267172

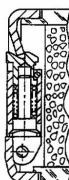
PARTIAL SECTION SHOWING PARTS ASSEMBLED  
FOR SEMIAUTOMATIC FIRE ONLY.



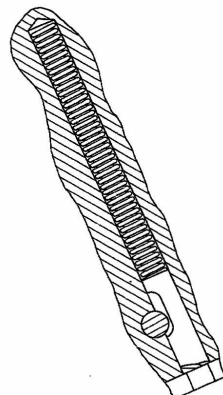
PARTIAL SECTION G-G  
(SH 3 ZONE G-4)



PARTIAL SECTION E-E  
(SH 2 ZONE B-8)



PARTIAL SECTION F-F  
(SH 3 ZONE G-4)



REVISIONS			
LTR	DESCRIPTION	DATE	APPROVED
AB	REDESIGNED WITH CHANGES, WAS 2" SIZE	21 JUN 68	J.R.K.
AC	SEE ED NO. 542 2333	3 OCT 68	J.R.K.
AD	SEE ED NO. 542 2333	11 MAR 69	J.R.K.
AE	SEE ED NO. 542 2333	22 JUL 70	J.R.K.
AF	SEE ERR HOR 30617	22 JAN 73	J.R.K.
AG	INOR WSS2022/79-03-26	79-04-01	J.R.K.
AH	INOR WSS20107/85-08-26	86-01-24	J.R.K.

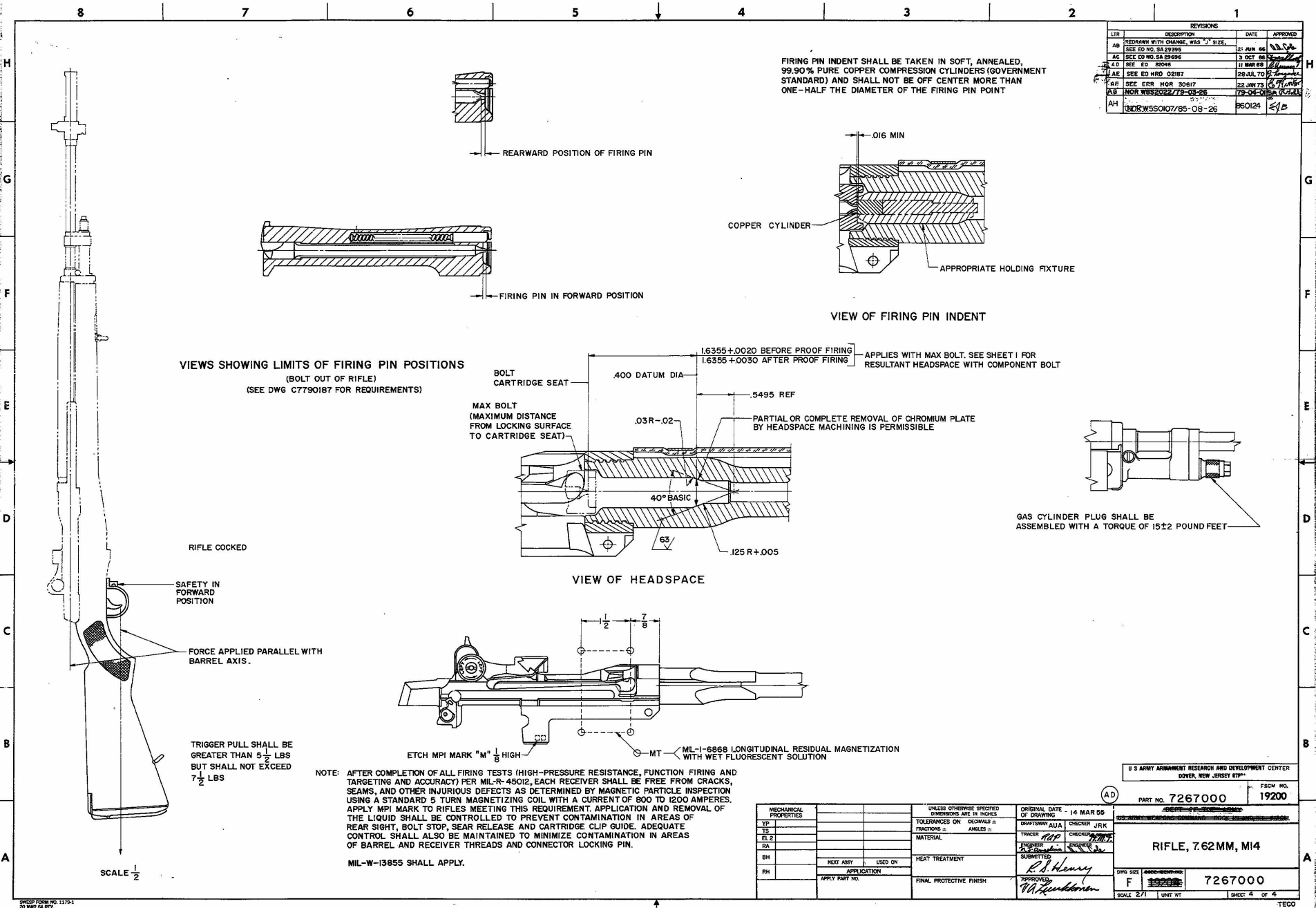
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOWRY, NEW JERSEY 07001

AD PART NO. 7267000 FSCM NO. 19200

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 14 MAR 55	
TEMP		TOLERANCES ON DECIMALS =		DRAWN BY	CHECKED
TS		FRACTIONS =		TRACED BY	CHECKED
EL 2		ANGLES =		REVIEWED BY	CHECKED
SA				SUBMITTED	
BH					
NEXT ASSY USED ON		HEAT TREATMENT		APPROVED	
APPLICATION		FINAL PROTECTIVE FINISH		APPROVED	
APPLY PART NO.				APPROVED	

RIFLE, 7.62 MM, M14	
DWG SIZE	7267000
F 19200	7267000
SCALE 2/1	SHEET 3 OF 4



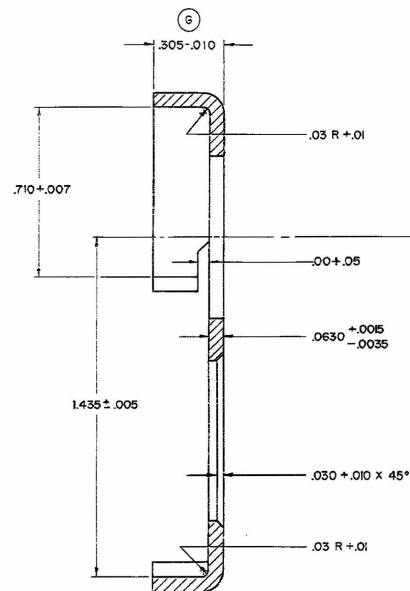


1178

6 5 4 3 2 1

NOTES:

1. FINISH  $125\sqrt{\text{ALL OVER}}$ .
  2. ALL EDGES SHALL BE BROKEN .005  $\pm$  .010 UNLESS OTHERWISE SPECIFIED.
  3. MATERIAL: STEEL, SPEC QQ-S-700: GRADE 1035, 1050; DRAWING QUALITY, (M)
  4. HEAT TREATMENT:
    - FOR 1035, 1050: HEAT AT 1525°F TO 1550°F. OIL QUENCH. TEMPER 30 MINUTES AT HEAT TO ROCKWELL C30-35.
    - FOR .17/24 CARBON STEEL: CARBURIZE AT 1575°F TO 1600°F FROM .005 TO .008 DEPTH. OIL QUENCH. TEMPER 30 MINUTES AT 350°F TO 425°F: FILE HARD.
- HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED. THE USE OF STRAIGHT CYANIDE BATH OR CARBO-NITRIDING PROCESS SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF THE CONTRACTING OFFICER.
5. MIL-W-13855 SHALL APPLY. (J3) (L)

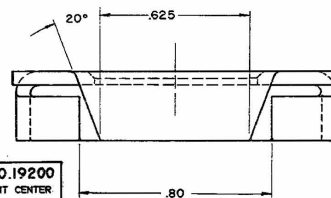


SECTION A-A

CURRENT DESIGN ACTIVITY FSCM NO.19200  
US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

ORIGINAL DESIGN ACTIVITY FSCM NO.19205

PHYSICAL PROPERTIES		TOLERANCES ON DIMENSIONS		ORIGINAL DATE OF DRAWING	
VP	17	DECIMALS 2, 3		17 SEP 1954	
EL2	F7267000 RIFLE, M14	MATERIAL		TRACER	
IN		HEAT TREATMENT		SUBMITTED	
IN		HEAT TREATMENT		R.D. Henry	
SEE NOTE	4.3.3	APPLY PART NO.		APPROVED BY	
FILED		FINISH NO. 5.3.12 OF MIL-STD-171		SCALE 4/1 UNIT WT	



R	NOR W4S2051/840824	860121	MR
P	NOR W2S20253/84020	84-04-20	
N	NOR WBS2022/79-02-26	79-04-01	
M	(3) SEE ERR HQR 40681	11 FEB 79	
L	SEE EO HRO 02158	11 FEB 79	
K	(1) SEE EO HRO 92078-2	22 SEP 80	
J	(1-3) SEE EO 82048	11 MAR 80	
H	(1-2) SEE EO SA29261	11 MAR 80	
GA	SEE EO SA 26457	11 MAR 80	
PA	SEE EO SA 26158	11 MAR 80	
E	SEE EO SA 24763	11 MAR 80	
D	REDRAWN AND REVISED SEE		
EO	SA 24529		
C			
DATE			
APPROVAL			

BAND, FRONT

7267001

D 07267001

C

B

A

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## D

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CD

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KCAD 890901

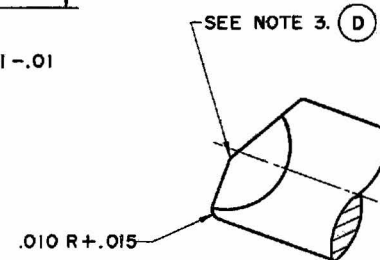
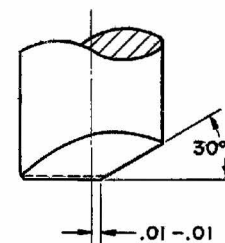
LATEST REVISION CAD GENERATED AT ORFI, MALVERN (KE5B)

NOTES:

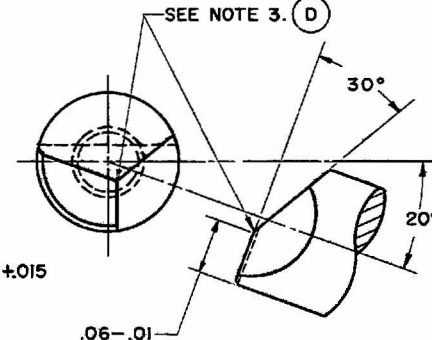
1. FINISH 125/ EXCEPT AS NOTED.
2. ALL EDGES SHALL BE BROKEN .005 +.010 UNLESS OTHERWISE SPECIFIED.
3. BLEND CORNER WITH A .015 +.030 SPHERICAL RADIUS. THIS CORNER IS AN IMPORTANT FUNCTIONING POINT AND SHALL BE SMOOTH AND FREE FROM BURRS.
4. MATERIAL: STEEL, CMPSN 1060, SPEC ASTM A575, A576: FRACTURE GRAIN SIZE 7 OR FINER. (FI) (J)

5. HEAT TREATMENT: HEAT TO 1500° - 1550° F. OIL QUENCH. TEMPER 20 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED. (C)
6. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OF MIL-STD-17L. (HI) (L)

7. MIL-W-13855 SHALL APPLY. (K)



ALTERNATIVE DESIGN (E)



C7267014

ORIGINAL FSCM NO. 19205

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

PART NO. 7267014

N	ECPW5S2069 R/851223	860121	
M	NOR WBS2022/79-03-26	79-04-01	
W/L	(2) SEE ERR HQR 40681	NOV 87	
K	SEE EO HRD 02138	7 FEB 88	
J	SEE EO HRD 02136	7-2870	
H	(1-2) SEE EO HRD 92078-2	25 JUNE 88	
G	(1-2) SEE EO 82048	8 MAR 88	
F	(1-2) SEE EO SA 29262	18 MAY 88	
E	SEE EO SA 26580	22 OCT 88	
D	SEE EO SA 26268	25 JUL 88	
C	SEE EO SA 26060	1 MAR 88	
B	REDRAWN AND REVISED		
A	SEE EO SA 24529	10 JUL 88	
SYN		10 MAR 88	

PHYSICAL PROPERTIES		TOLERANCES ON DECIMALS		ORIGINAL DATE OF DRAWING 26 AUG 54
YP		ANGLES ± 2°	FRACTIONS	
TS		MATERIAL		DRAFTSMAN C. W. M. CHECKER
EL 2	B7267015	RIFLE, M14		TRACER
RA		SEE NOTE 4		ENGINEER
BN		HEAT TREATMENT		SUBMITTED
		SEE NOTE 5		APPROVED BY ORDER OF THE CHIEF OF BRANCH
RW	C45-50	FINAL PROTECTIVE FINISH		APPROVED BY ORDER OF THE CHIEF OF BRANCH
		SEE NOTE 6		

EJECTOR

DEPT OF THE ARMY	
ROCK ISLAND ARSENAL	
ROCK ISLAND ILL	
41201	
DWG NO	7267014
SIZE	C
SCALE	10/1
UNIT WT	
SHEET	1 of 1

00 FORM 1176  
1 APR 54

NOTICE: This drawing, specification, or other data are used for the purpose of showing the design of a part in connection with a Government procurement contract, the United States Government thereby issues no warranty or any other statement and the fact that the Government may have furnished, furnished, or may furnish the said drawings, specifications or other data is not to be construed as a recommendation or endorsement by the Government or any other person, organization, or agency in any way or as an endorsement, use, or sale of any product or service that may in any way be related thereto.

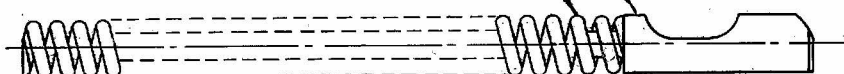
NOTES:

(C)

1. MIL-W-13855 SHALL APPLY.

EJECTOR - 7267014

SPRING - 7267959



ORIGINAL FSCM NO. 19205

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

(F) (G)

FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 7267015.

CODE IDENT NO. ~~19204~~

PART NO. 7267015

(E)

C7790187		RIFLE, M14		RIFLE, M14	
NEXT ASSY		USED ON		APPLICATION	
DO NOT		APPLY PART NO.		SUBMITTED	
PHYSICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED		ORIGINAL DATE OF DRAWING 17 SEP 1954	
YP		DIMENSIONS ARE IN THICKES		DRAFTSMAN E.K. CHECKER E.K.	
TS		TOLERANCES ON		TRACER G.F.B. CHECKER E.K.	
EL2		FRACTIONS DECIMALS ANGLES		EJECTOR HORN E.K. CHECKER E.K.	
RA		MATERIAL		SUBMITTED	
BH		HEAT TREATMENT		R.S. Henry	
RH		FINAL PROTECTIVE FINISH		APPROVED BY CHIEF OF THE DIVISION OF ORDNANCE	

EJECTOR  
ASSEMBLY,  
CARTRIDGE

DEPT. OF THE ARMY  
U.S. ARMY WEAPONS  
COMMAND  
ROCK ISLAND, ILL. 61201

OWN SIZE 7267015

B SHEET 1 OF 1

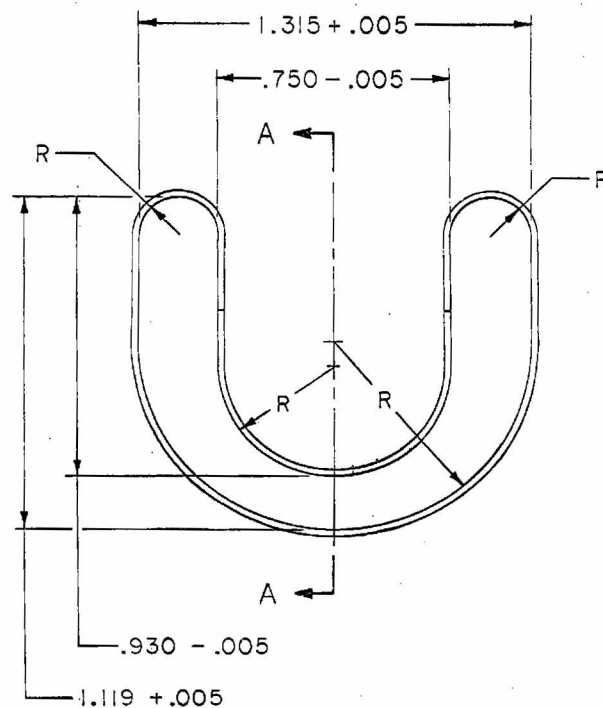
R. M. H.

B7267015

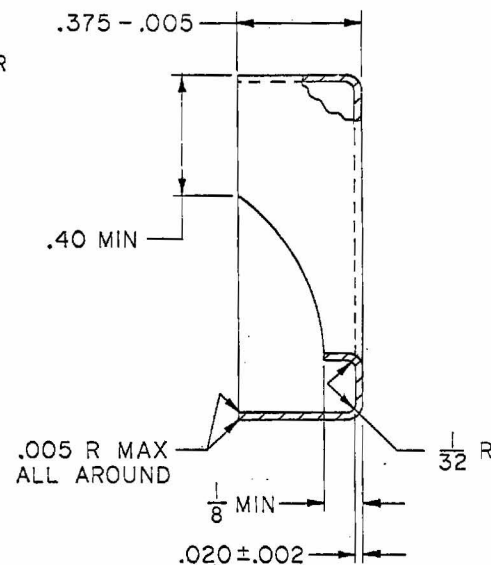
REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
A		15 SEP 55	
B	REDRAWN W/O CHANGE	10 JUL 58	R. Henry
C	SEE EO SA26580	22 OCT 63	
D	SEE EO SA 29261	18 MAY 66	
E	SEE EO 82048	11 MAR 68	
F	(1) SEE EO HRD 92078-2	25 JUN 69	
G	SEE EO HRD 02138	71 FEB 75	
H	NOR W8S2022/79-03-26	79-04-01	SAB 8-21
J	NOR W4S2051/840824 ECPW5S2069 / 851223	86012L	

# NOTES:

1. STEEL, DRAWING QUALITY, SPEC ASTM A619.
2. FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.
3. MIL-W-13855 APPLIES.
4. ANSI Y14.5 APPLIES.



REVISIONS				
MP	ZONE	LTR	DESCRIPTION	DATE
		M	REPLACES REV L W/CHNG	
			SEE ERR HCR 40681	10 FEB 75
		N	NOR W852022/79-03-26	79-04-01 SA R.H.H.
		P	NOR W252025/84-02-10	8404-20
		R	NOR W:50034/810915	860811 MR H.T.
		T	ERR 2921171U (ECP W250056/821116)	891010



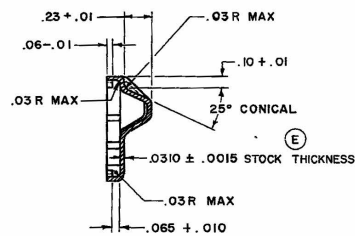
CURRENT DESIGN ACTIVITY FSCM NO.19200  
 US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
 DOVER, NEW JERSEY 07801

PART NO. 7267017

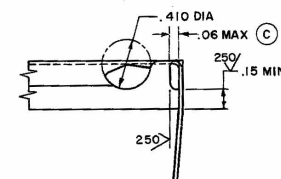
MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING		SPRINGFIELD ARMOY, SPRINGFIELD, MA	
YS MIN				4 OCT. 54.			
YS MAX				DRAFTSMAN W.S.C.	CHECKER P.V.		
EL 2				TRACER	CHECKER		
RA	F11685527	RIFLE, M14A1		ENGINEER R.W.D.	ENGINEER		
BH	F11010263	RIFLE, M14		SUBMITTED			
RH	F11685427			APPROVED D.S.BUTTERWORTH			
	NEXT ASSY.	USED ON	FINAL PROTECTIVE FINISH	A.A.COLE		DWG SIZE C	CODE IDENT NO. 19205
	APPLICATION		SEE NOTE 2			7267017	

SCALE 4/1	UNIT WT	SHEET 1 OF 1
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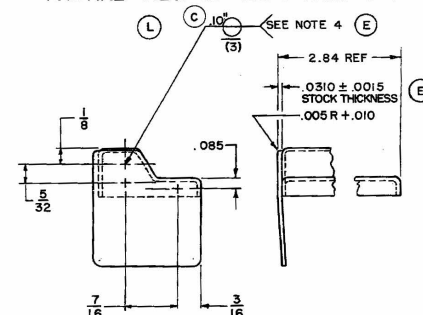
1. FINISH <sup>125</sup>✓ EXCEPT AS NOTED.
2. ALL CORNERS AND EDGES SHALL BE BROKEN .003 & .010 UNLESS OTHERWISE SPECIFIED.
3. MATERIAL: STEEL, SPEC Q0-S-CARBON .08/19, DRAWING QUALITY
4. WELD SHALL WITHSTAND PEEP TEST PER MIL-W-12332, EXCEPT THAT IN LIEU OF MIN BUTTON DIA REQUIREMENT THE WELD SHALL BE A FACTOR OF 2 TO THE PEEP TEST CAUSES TEARING OF BASE METAL AROUND THE PERIPHERY OF THE WELD.
5. MIL-W-38655 SHALL APPLY.



DETAIL F SCALE 10/1  
ALTERNATIVE DESIGN



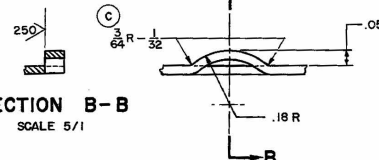
PARTIAL VIEW OF LEFT HAND SIDE



**ALTERNATIVE DESIGN**  
ALTERNATIVE TYPE WELD: PROJECTION



**SECTION B-B**  
SCALE 5/1




DETAIL E  
SCALE 5/1

ORIGINAL FSCM NO. 19205

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
FOUR NEW VEHICLES

PART NO. 7267018

<b>PHYSICAL PROPERTIES</b>				WHERE SPECIFIED EXCEEDS DIMENSIONS OR IS IN EXCESS OF TOLERANCES ON DECIMALS & FRACTIONS $\frac{1}{64}$		ORIGINAL DATE OF DRAWING 18 OCT 1954 DRAWN BY R.F.C. CHECKED J.K. FACED BY J.K. INDEXED J.K. ENGINEERED BY ENGINEER S.W. SUBMITTED		REVISIONS	
72		RIFLE M4MNM		SEE NOTE 3		<b>FOLLOWER, MAGAZINE</b>  		DEPT. OF THE ARMY	
ELI	C7267019	RIFLE M14						ROCKISLAND ARSENAL	
DA								ROCKISLAND, ILL.	
	NEXT ASBY	USED ON		HEAT TREATMENT					
	APPLICATION			AT ASSEMBLY					
III	DO NOT APPLY PART NO.			FINAL PROTECTIVE FINISH					
	SUB	INFORM.		AT ASSEMBLY				ONE SIDE SEE D 7267019	
						SCALE 2/1 LIMIT MAX			

FOLLOWER,  
MAGAZINE

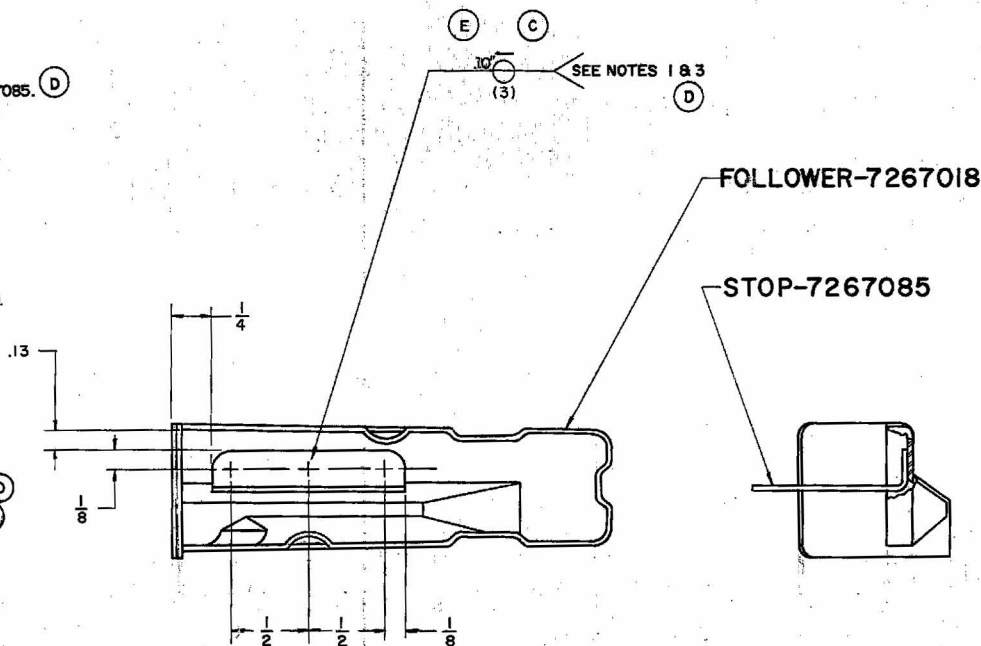
~~DEPT OF THE ARMY~~  
~~ROCK ISLAND ARSENAL~~  
~~ROCK ISLAND, ILL 632~~

7267018
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R. M. H.

NOTES:

1. ALTERNATIVE TYPE WELD: PROJECTION. PROJECTIONS SHALL BE FORMED ON STOP-7267085. (D)
2. HEAT TREATMENT: CARBURIZE AT 1575°-1600°F FROM .005 TO .008 DEPTH. OIL QUENCH, TEMPER 30 MINUTES AT 375°F TO HARDNESS SPECIFIED.
3. WELD SHALL WITHSTAND PEEL TEST PER MIL-W-12332, EXCEPT THAT IN LIEU OF MINIMUM BUTTON DIAMETER REQUIREMENT THE WELD SHALL BE SATISFACTORY IF THE PEEL TEST CAUSES TEARING OF THE BASE METAL AROUND THE PERIPHERY OF THE WELD.
4. HEAT TREATMENT METHOD (SEE NOTE 2) IS FOR GUIDANCE EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED. THE USE OF STRAIGHT CYANIDE BATH OR CARBO-NITRIDING PROCESS SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF THE CONTRACTING OFFICER.
5. MIL-W-13855 SHALL APPLY.
6. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171. (G1)



ORIGINAL FSCM NO. 19205

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST: 7267019

PART NO. 7267019

PHYSICAL PROPERTIES		TOLERANCES ON DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED: DECIMALS ±.01 FRACTIONS ±.005		ORIGINAL DATE OF DRAWING 18 OCT 1954 DRAWN BY D.F.B. CHECKED J.K. DESIGNED BY C.M. CHECKED J.K. APPROVED BY R.D. Henry DATE 10 FEB 75
ITEM	DESCRIPTION	QUANTITY	UNIT	REVISIONS
1	RIFLE M4NM			
2	RIFLE M14			
3	HEAT TREATMENT	SEE NOTE 2 & 4		
4	FINAL PROTECTIVE FINISH	SEE NOTE 6		

FOLLOWER ASSY,  
MAGAZINE

7267019

N	ECPW552069 / 7851223	950121	4/
M	NOR WBS2022/79-03-26	790901	5/
L	(1) SEE ERR HQR 4068	10 FEB 75	
K	SEE EO HQR 10609	7 MAY 79	
J	SEE EO HRD 02138	21 FEB 75	
H	(1) SEE EO HRD 92078-2	25 JUN 75	
G	(1) SEE EO 82046	11 MAR 76	
F	(1) SEE EO SA 29261	10 MAR 76	
E2	SEE EO SA 26221	11 MAR 76	
D4	SEE EO SA 25971	22 DEC 76	
C	SEE EO SA 24963	23 OCT 76	
B	REDRAWN AND REVISED	12 JUN 76	
A	SEE EO SA 24622		
SYN		DATE	APPROVAL



**C**

- A



A

REVISIONS

DEPT OF THE ARMY
ROCK ISLAND ARSENAL
ROCK ISLAND ILL 61001

GUIDE,  
RATING ROD

DWG SIZE	7267025
C	

UNIT NO

PHYSICAL PROPERTIES		TOLERANCES SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 14 OCT 54
TP		RIFLE, M21	TOLERANCES ON DECIMALS	DRAFTSMAN C.W.M. CHECKER
TS	J7790476	RIFLE, M14NM	ANGLES 2° FRACTIONS 2/164	TRACER R.G. CHECKER
EL 2	F7267000	RIFLE, M14	MATERIAL	ENGINEER <del>NOT</del> ENGINEER
RA			SEE NOTE 3	SUBMITTED
SH		NEXT ASST USED ON	HEAT TREATMENT	R.S. Henry
		APPLICATION	SEE NOTE 4	ORD CORPS
RI	C 32-40	DO NOT APPLY PART NO.	FINAL PROTECTIVE FINISH	APPROVED BY ORDER OF THE CHIEF OF ORDNANCE
			SEE NOTE 5	H. G. Carl

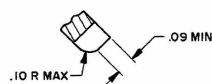
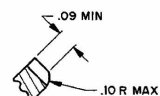
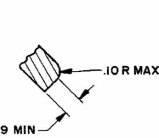
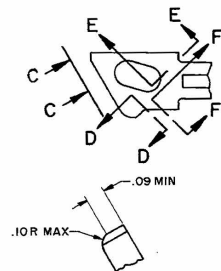
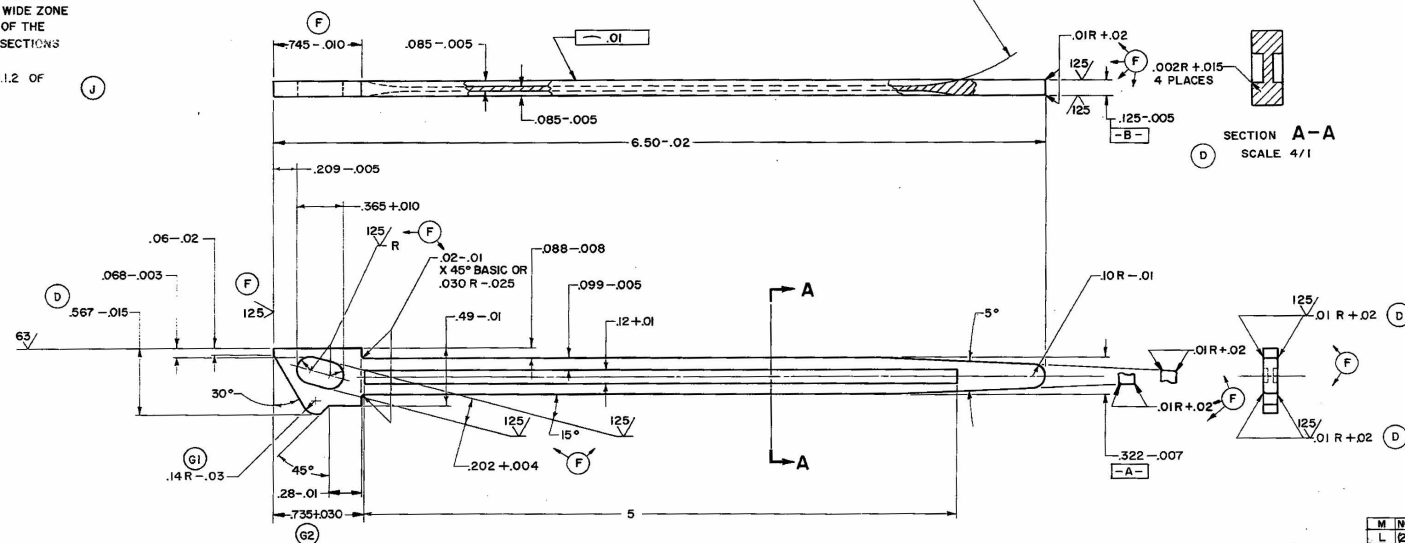
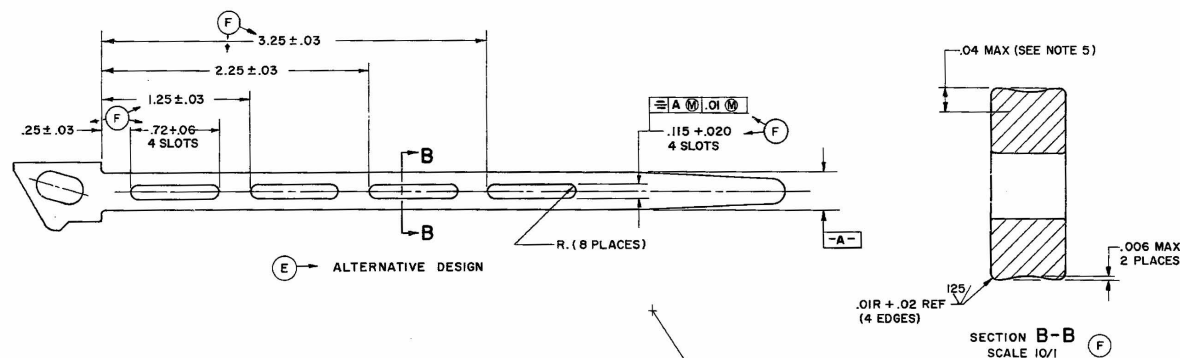
# GUIDE, OPERATING ROD

~~DEPT OF THE ARMY~~  
~~ROCK ISLAND ARSENAL~~  
~~ROCK ISLAND, ILL 61201~~

DWG SIZE	7267025
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RMH

1. FINISH 250/ EXCEPT AS NOTED. (F)
2. ALL EDGES SHALL BE BREAKEN .005 +.015 UNLESS OTHERWISE SPECIFIED.
3. MATERIAL : STEEL ASTM A506 @ 8640, 8645. (F) (L)
4. HEAT TREATMENT: HEAT TO 1525° - 1550° F. QUENCH IN CIRCULATING OIL. TEMPER 45 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT-TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED. SURFACE DECARBURIZATION SHALL NOT EXCEED .001 TOTAL. (E) (F)
5. DIE ROUNDS RESULTING FROM STAMPING ARE PERMISSIBLE AT ONE SIDE OF DIMENSION [C-B] ONLY, AND SHALL NOT REDUCE DIMENSION [B-B] BY MORE THAN .005 FROM ITS ACTUAL SIZE WITHIN A .04 MAX WIDE ZONE ALONG THE COMPLETE PERIPHERY OF THE COMPONENT, EXCEPT AS SHOWN IN SECTIONS D-D, E-E, F-F AND VIEW C-C.
6. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OF MIL-STD-171. (L)
7. MIL-W-13855 SHALL APPLY.



VIEW C-C  
SCALE 4/1

SECTION D-D  
SCALE 4/1

SECTION E-E  
SCALE 4/1

SECTION F-F  
SCALE 4/1

(F) ALTERNATIVE DESIGN (SEE NOTE 5)

[illegible]

L	M	NR WBS92022/79-03-26	1790401	SAF	1790401
L	2	SEE ERR RHO 4068	07FEB78		
K	5	SEE EO HRD 02138	71FEB78		
J	12	SEE EO HRD 92078-2	25JAN69		
H	1	SEE EO 82048	18MARG69		
G	11	4 SEE EO 524261	18MAY69		
D	6	SEE EO SA 28574	13JUN69		
E	4	SEE EO SA 26C59	11MAR 69		
C	2	SEE EO SA 28023	31JAN 69		
C	2	REDRAWN AND REVISED SEE EO SA 24529	30JUL59		
		WAS 'C' SIZE			
B			28DEC54		
BY		DESCRIPTION	DATE	APPROVAL	
		REVISIONS			

GUIDE,  
SPRING

DEPT OF THE ARMY

ROCK ISLAND AND ARSENAL

ROCK ISLAND, ILL-61201

ONE  
D

7260727

2/1 UNIT WT

SHEET

OF

NOTES:

1. FINISH 125/ EXCEPT AS NOTED.  
2. ALL EDGES SHALL BE BRCKEN .006+ .010 UNLESS OTHERWISE SPECIFIED.

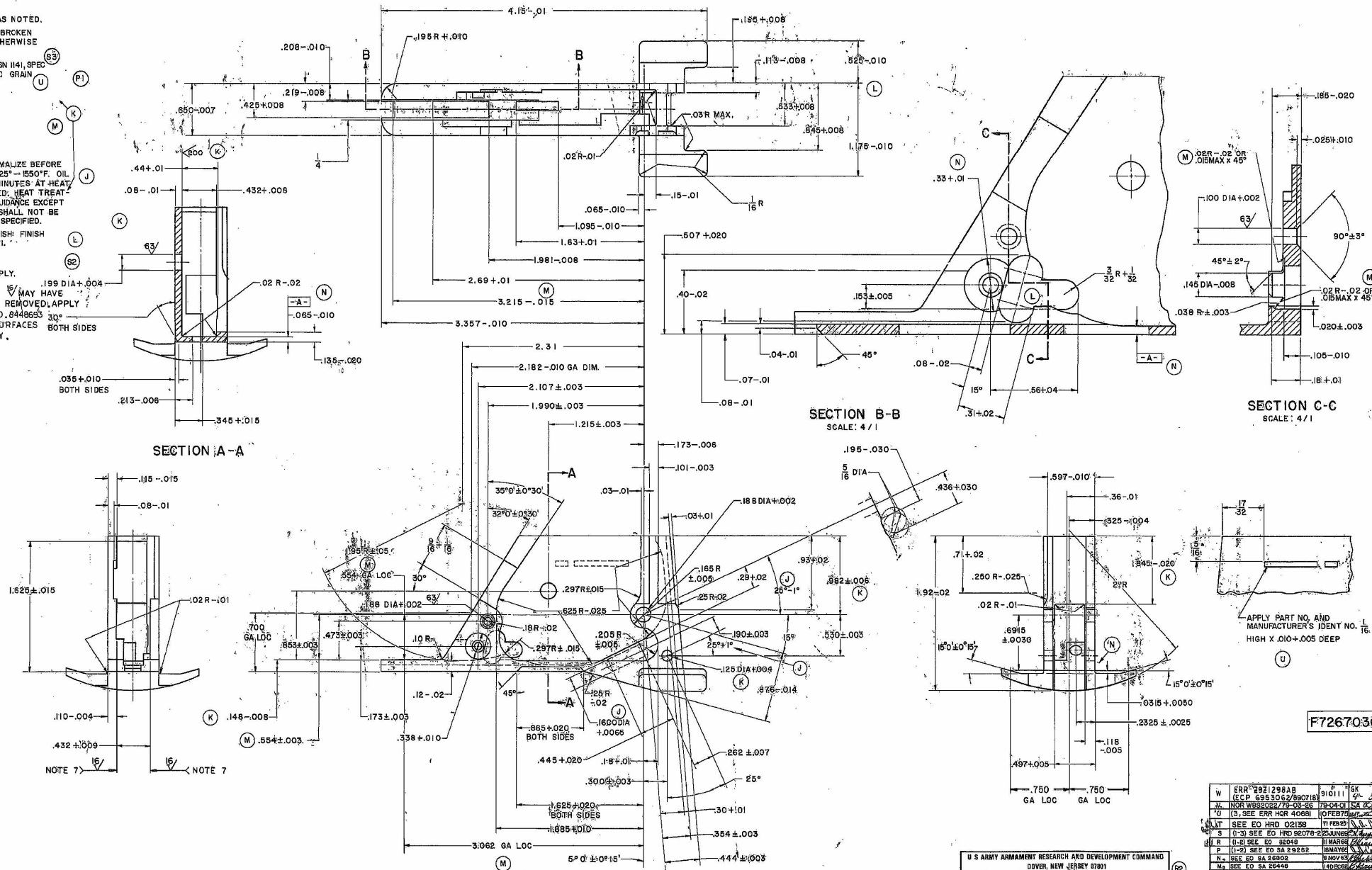
3. MATERIAL: STEEL, CMPSN 1141, SPEC. QQ-S-637, AUSTENITIC GRAIN SIZE 7 OR FINER.

4. HEAT TREATMENT: NORMALIZE BEFORE MACHINING. HEAT TO 1525°-1550°F. OIL QUENCH. TEMPER 30 MINUTES AT HEAT TO ROCKWELL SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.

5. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OF MIL-STD-171.

6. MIL-W-13855 SHALL APPLY.

7. SURFACES FINISHED 16/ MAY HAVE PROTECTIVE FINISH REMOVED. APPLY LUBRICANT DWG. NO. 6448653 30° TO THE FINISHED SURFACES BOTH SIDES PRIOR TO ASSEMBLY.



F7267030

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND  
DOVER, NEW JERSEY 07801

CODE IDENT. NO. 19205

CODE IDENT. NO. 19205

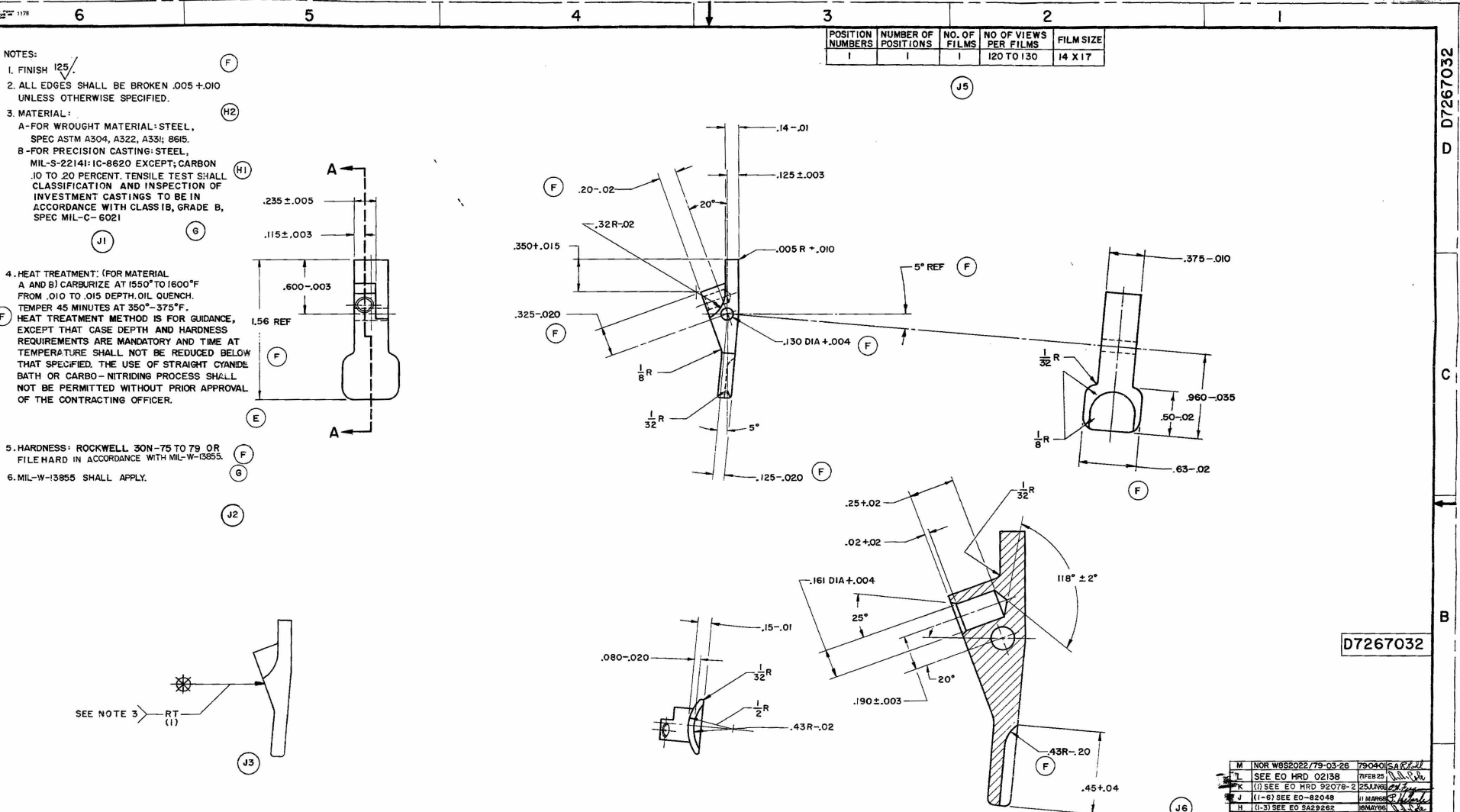
PART NO. 7267030

PHYSICAL PREPARED BY DATE DRAWN BY CHECKED BY APPROVED BY SPECIAL INSTRUCTIONS		RIFLE M2 RIFLE M14/M RIFLE M14 SEE NOTE 3 WAY TREATMENT SEE NOTE 4 FINAL PHOTOGRAPH SEE NOTE 5		TOLERANCES ON DIMENSIONS IN INCHES DECIMALS IN FRACTIONS ANGLES IN DEGREES UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS		ORIGINAL DATE OF DRAWING OCT 1954 DRAWN BY CHECKED BY APPROVED BY SPECIAL INSTRUCTIONS	
19205 7267030		19205 7267030		19205 7267030		19205 7267030	

HOUSING, TRIGGER

SPRINGFIELD ARMYORY  
ORDNANCE WORKS  
DEPT OF THE ARMY

7267030



NOTES:  
1. FINISH 125/  
2. ALL EDGES SHALL BE BROKEN .005 ± .010 UNLESS OTHERWISE SPECIFIED.  
3. MATERIAL:  
A-FOR WROUGHT MATERIAL: STEEL, SPEC ASTM A304, A322, A334; 8615.  
B-FOR PRECISION CASTING: STEEL, MIL-S-22141: 1C-8620 EXCEPT; CARBON .10 TO .20 PERCENT. TENSILE TEST SHALL CLASSIFICATION AND INSPECTION OF INVESTMENT CASTINGS TO BE IN ACCORDANCE WITH CLASS 1B, GRADE B, SPEC MIL-C-6021  
4. HEAT TREATMENT: (FOR MATERIAL A AND B) CARBURIZE AT 1550° TO 1600°F FROM .010 TO .015 DEPTH. OIL QUENCH. TEMPER 45 MINUTES AT 350°-375°F.  
HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED. THE USE OF STRAIGHT CYANIDE BATH OR CARBO-NITRIDING PROCESS SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF THE CONTRACTING OFFICER.  
5. HARDNESS: ROCKWELL 30N-75 TO 79 OR FILE HARD IN ACCORDANCE WITH MIL-W-13855.  
6. MIL-W-13855 SHALL APPLY.

POSITION NUMBERS	NUMBER OF POSITIONS	NO. OF FILMS	NO. OF VIEWS PER FILM	FILM SIZE
1	1	1	120 TO 130	14 X 17

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND  
DOVER, NEW JERSEY 07801

SECTION A-A  
SCALE 4/1

PHYSICAL PROPERTIES	CODE IDENT NO. 19200
ITEM	RIFLE XM21
TYPE	RIFLE M14-NM
ELI	C7790196
MA	RIFLE, M14
HEAT TREATMENT	SEE NOTE 3
DO NOT	APPLY PART NO.
DO	APPLY PART NO.
DO NOT	APPLY PART NO.
DO	APPLY PART NO.

ORIGINAL DATE OF DRAWING 14 AUG 1954	ORIGINAL DATE OF DRAWING 14 AUG 1954
DESIGNED BY C. W. B. CHECKED BY C. W. B.	DESIGNED BY C. W. B. CHECKED BY C. W. B.
TRACER C. W. B. CHECKED BY C. W. B.	TRACER C. W. B. CHECKED BY C. W. B.
ENGINEER A. N. CHECKED BY C. W. B.	ENGINEER A. N. CHECKED BY C. W. B.
SUBMITTED	SUBMITTED
APPROVED BY R. S. H. CHECKED BY C. W. B.	APPROVED BY R. S. H. CHECKED BY C. W. B.
APPROVED BY R. S. H. CHECKED BY C. W. B.	APPROVED BY R. S. H. CHECKED BY C. W. B.
APPROVED BY R. S. H. CHECKED BY C. W. B.	APPROVED BY R. S. H. CHECKED BY C. W. B.
APPROVED BY R. S. H. CHECKED BY C. W. B.	APPROVED BY R. S. H. CHECKED BY C. W. B.

REVISIONS	REVISIONS
DATE	DATE
APPROVAL	APPROVAL
DATE	DATE
APPROVAL	APPROVAL
DATE	DATE
APPROVAL	APPROVAL
DATE	DATE
APPROVAL	APPROVAL

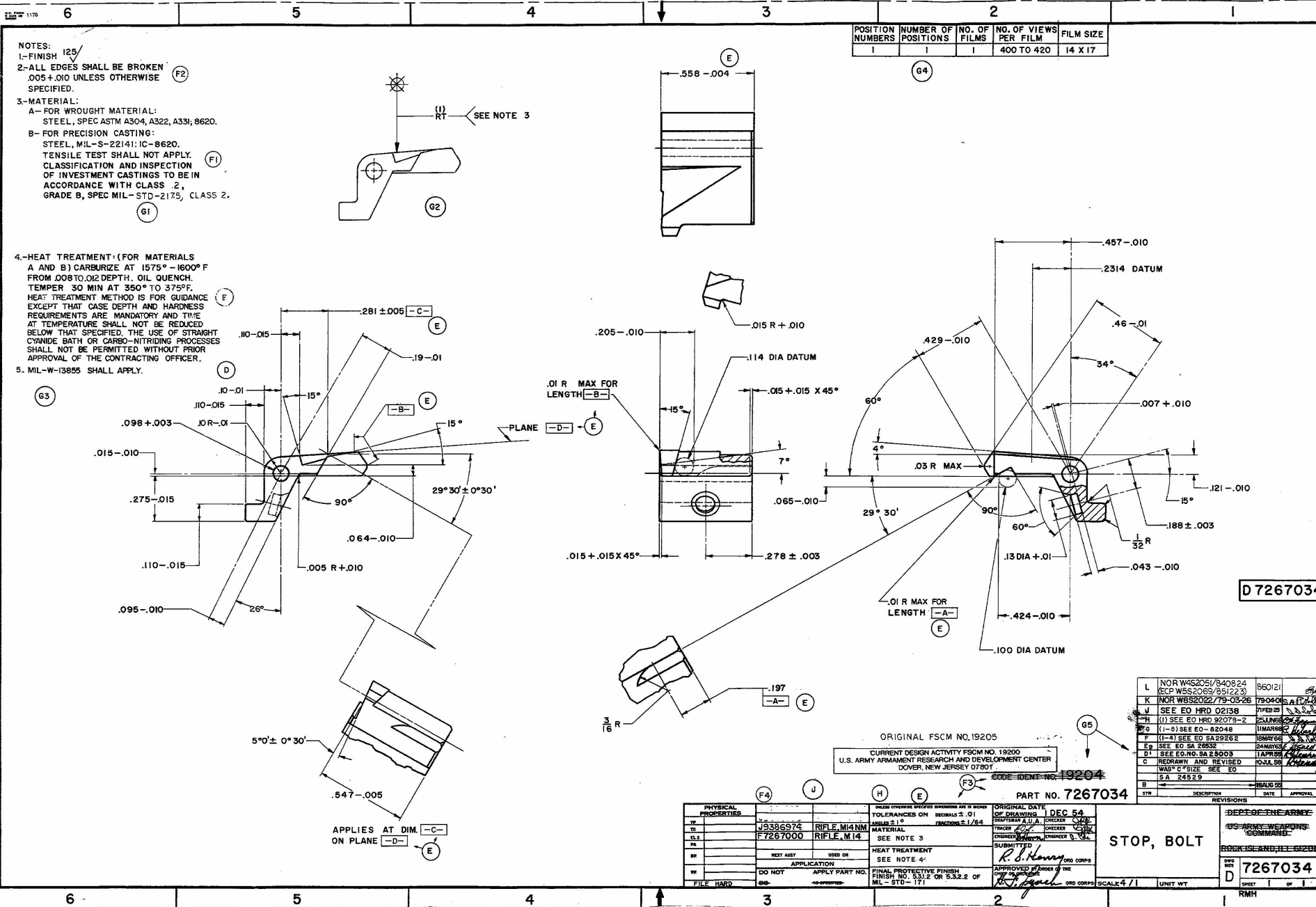
LATCH, MAGAZINE  
SCALE 2/1 UNIT WT  
RWH

D7267032

D7267032

B

A



NOTES:  
1-FINISH 125/  
2-ALL EDGES SHALL BE BROKEN .005 ± .010 UNLESS OTHERWISE SPECIFIED.  
3-MATERIAL:  
A- FOR WROUGHT MATERIAL:  
STEEL, SPEC ASTM A304, A322, A331, 8620.  
B- FOR PRECISION CASTING:  
STEEL, MIL-S-22141: 1C-8620.  
TENSILE TEST SHALL NOT APPLY.  
CLASSIFICATION AND INSPECTION OF INVESTMENT CASTINGS TO BE IN ACCORDANCE WITH CLASS 2, GRADE B, SPEC MIL-STD-2175, CLASS 2.

4-HEAT TREATMENT: (FOR MATERIALS A AND B) CARBURIZE AT 1575°-1600° F FROM .008 TO .012 DEPTH. OIL QUENCH. TEMPER 30 MIN AT 350° TO 375° F. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED. THE USE OF STRAIGHT CYANIDE BATH OR CARBO-NITRIDING PROCESSES SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF THE CONTRACTING OFFICER.  
5. MIL-W-13855 SHALL APPLY.

POSITION NUMBERS	NUMBER OF POSITIONS	NO. OF FILMS	NO. OF VIEWS PER FILM	FILM SIZE
1	1	1	400 TO 420	14 X 17

PHYSICAL PROPERTIES	9386974 RIFLE M14NM	9386974 RIFLE M14NM	9386974 RIFLE M14NM	9386974 RIFLE M14NM
TEMP	100	100	100	100
STRESS	100	100	100	100
PA	100	100	100	100
BR	100	100	100	100
DO NOT	100	100	100	100
FILE HARD	100	100	100	100

L	NOR W52051/840R24	860121	860121
K	ECF W52069/851223	790401	790401
J	SEE EO HRD 02138	710121	710121
H	(1) SEE EO HRD 92078-2	24JAN68	24JAN68
G	(1) SEE EO-82049	UNAWAR	UNAWAR
F	(1) SEE EO SA 29262	24MAY68	24MAY68
E	SEE EO SA 26832	24MAY68	24MAY68
D	SEE EO NO. SA 25008	14APR68	14APR68
C	REDRAWN AND REVISED	10JUL68	10JUL68
B	WAS "C" SIZE SEE EO	SA 24529	SA 24529
A	SA 24529	REVAL 58	REVAL 58

STOP, BOLT  
D 7267034  
SCALE 4/1 UNIT WT  
RMH

00 FORM 1176

NOTICE: This drawing, specification, or other data are used for procurement other than in connection with a contract awarded by the United States Government. The Government makes no representation as to the accuracy, reliability, or completeness of the information contained herein, and the fact that the Government may have furnished, furnished, or may supply the said drawings, specifications or other data is not to be regarded as an endorsement or approval by the Government of the use, or of any other person's use, of the same in any way.

B7267035

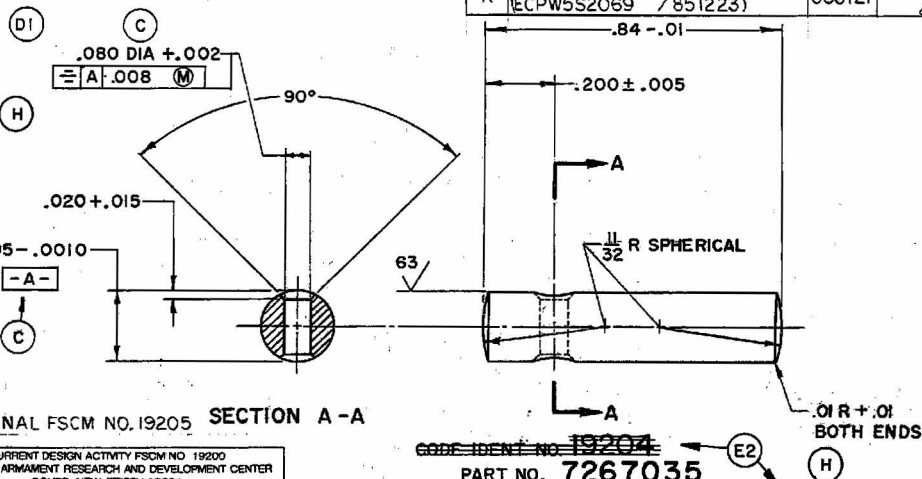
NOTES:

1. FINISH 125/ EXCEPT AS NOTED.

2. MATERIAL: STEEL, ASTM A108, 1019 THRU 1022

3. HEAT TREATMENT: CARBURIZE AT 1575° TO 1600°F FROM .006 - .010 DEPTH. OIL QUENCH. TEMPER 20 MINUTES AT 350° - 375°F. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED. THE USE OF STRAIGHT CYANIDE BATH OR CARBO-NITRIDING PROCESSES SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF THE CONTRACTING OFFICER.

4. MIL-W-13855 SHALL APPLY.



REV	DESCRIPTION	DATE	APPROVAL
A	REDRAWN AND REVISED	19 OCT 54	
B	SEE EO SA 24529	10 JUL 58	
C	SEE EO SA 26974	21 AUG 63	
D	(1-2) SEE EO SA 29262	18 MAY 66	
E	(1-2) SEE EO 82048	11 MAR 68	
F	(1) SEE EO HRD 92078-2	25 JUN 69	
G	SEE EO HRD 02138	71 FEB 75	
H	(2) SEE ERR HQR 40681	10 FEB 75	
J	NOR WBS2022/79-03-26	79-04-01	
K	NORW4S2051/840824 ECPW5S2069 / 851223	860121	

ORIGINAL FSCM NO. 19205 SECTION A-A

CODE IDENT NO. 19204

PART NO. 7267035

F9352636 RIFLE, M14NM		F7790191 RIFLE, M14	
TP	TS	EL2	RA
NEXT ASSY		USED ON	
APPLICATION			
DO NOT	APPLY PART NO.	FILE HARD	

PHYSICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED	
TP	TS	DIMENSIONS ARE IN INCHES	
RA		TOLERANCES ON FRACTIONS DECIMALS ANGLES	
BH		± 1/64 ± 1°	
RH		MATERIAL SEE NOTE 2	
		HEAT TREATMENT SEE NOTE 3	
		FINAL PROTECTIVE FINISH FINISH S.S. 1.2 OF MIL-STD-171	

ORIGINAL DATE OF DRAWING	10 SEP 54
DRAWN BY	CHK
CHECKED BY	CHK
ENGR	CHK
SUBMITTED	
APPROVED BY	CHK
CHIEF OF PROJECT	

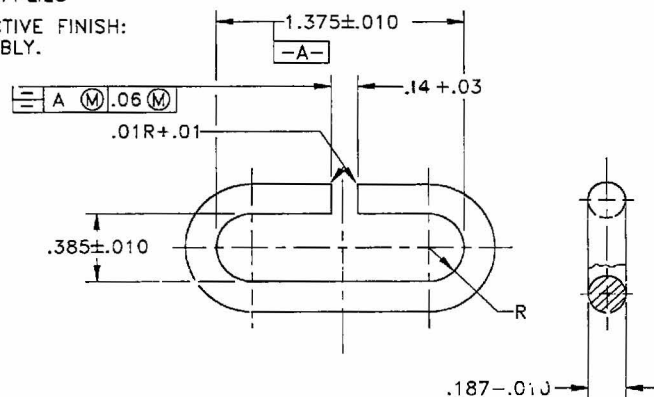
PIN, LOCKING, CONNECTOR

7267035	
B	SHEET 1 OF 1

DRAWING SIZE B

## NOTES:

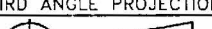
1. FINISH 125/ALL OVER.
2. MATERIAL: STEEL, GRADE 1018-1022 PER SPEC ASTM A108, A575, A576.
3. MIL-W-13855 APPLIES
4. ANSI Y14.5 APPLIES
5. FINAL PROTECTIVE FINISH: AFTER ASSEMBLY.



REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
N	REDRAWN WITH CHANGE ERR Z9Z1171U (ECP W2S0056/821116)	891010	ORFI JH
P	NOR W6S3067/861230	900404	ORFI LG
R	NORG052052/901211	910124	ET ER

CURRENT DESIGN ACTIVITY CAGE CODE 19200  
U.S. ARMY  
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER  
PICATINNY ARSENAL, NEW JERSEY 07806-5000

PART NO. 7267037

		MECHANICAL PROPERTIES	DO NOT SCALE DRAWING		ORIGINAL DATE OF DRAWING		SPRINGFIELD ARMOY SPRINGFIELD, MA		
			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		10 SEPT 54				
B9352716	RIFLE,M14NM		YP	TOLERANCES ON DECIMALS ±		DRAFTSMAN	CHECKER	LOOP, SWIVEL	
	MG,7.62MM:		YS			A.U.A.	E.J.K.		
	M60		EL2	FRACTIONS ±      ANGLES ±		ENGR	ENGR		
	RIFLE,M14	RA	THIRD ANGLE PROJECTION		D.H.	A.C.			
		BH			ENGR	ENGR			
NEXT ASSY	USED ON	RH			SUBMITTED		SIZE CODE IDENT NO.		
APPLICATION					R.S. HENRY	B 19205	7267037		
					APPROVED	H.F. LYNCH	SCALE 2/1	UNIT WT.	SHEET 1 OF 1

KCAD 891016

LATEST REVISION CAD GENERATED AT ORFI, MALVERN (KESA)



NOTES:

1. FINISH 125/ EXCEPT AS NOTED.
2. ALL EDGES SHALL BE BROKEN .005 + .010 UNLESS OTHERWISE SPECIFIED.
3. MATERIAL: STEEL, SPEC ASTM A304, A322, A331: 8645, 8640, 8642, 8740, AND 8742. AUSTENITIC GRAIN SIZE 5-8.
4. HEAT TREATMENT: HEAT TO 1540° - 1575° F. QUENCH IN CIRCULATING OIL. TEMPER 30 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
5. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.
6. MIL-W-13855 SHALL APPLY.

96 DP, 30° DIAMOND, CLASS I  
TOL PER ANSI B94.6-1984

.24 MIN KNURL  
.277 - .010  
.355 - .010  
63

-A-

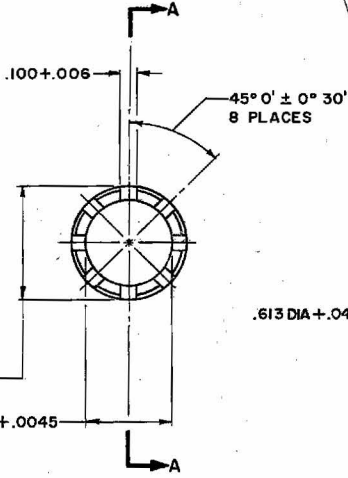
PHYSICAL PROPERTIES		TOLERANCES ON DECIMALS - FRACTIONS	
YP		ANGLES ± 1°	
TS		MATERIAL	SEE NOTE 3
CL 2	J9386974	RIFLE, M14	
RA	F7267000		
BR		HEAT TREATMENT	SEE NOTE 4
NR		APPROVED BY ORDER OF THE	
NR	A71.5-73.1	DO NOT	APPLY PART NO.
		FINAL PROTECTIVE FINISH	SEE NOTE 5

ORIGINAL DATE OF DRAWING 8 NOV 54		SUBMITTED	
DRAFTSMAN C. L. B.	CHECKER	ENGINEER	ENGINEER
TRACER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER

ORIGINAL DATE OF DRAWING 8 NOV 54		SUBMITTED	
DRAFTSMAN C. L. B.	CHECKER	ENGINEER	ENGINEER
TRACER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER

ORIGINAL DATE OF DRAWING 8 NOV 54		SUBMITTED	
DRAFTSMAN C. L. B.	CHECKER	ENGINEER	ENGINEER
TRACER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER

ORIGINAL DATE OF DRAWING 8 NOV 54		SUBMITTED	
DRAFTSMAN C. L. B.	CHECKER	ENGINEER	ENGINEER
TRACER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER



SECTION A-A

ORIGINAL FSCM NO. 19205

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

PART NO. 7267039

SYN	DESCRIPTION	DATE	APPROVAL
L	ECPW5S2069 / 851223	860121	
K	NOR WBS2022/79-03-26	79-04-01	
J	(2)SEE ERR HQR 4068	10 FEB 75	
H	SEE EO HRD 02138	71 FEB 75	
G	(1-4)SEE EO HRD 92078-2	25 JUN 75	
F	(1-3)SEE EO 82048	11 MAR 68	
E	(1-2)SEE EO SA 29261	12 MAR 68	
D	SEE EO SA 26558	11 MAR 63	
C	SEE EO SA 25969	23 DEC 60	
B	REDRAWN AND REVISED, WAS B SIZE. SEE EO SA 24529	10 JUL 58	
A		22 NOV 54	

NUT, FLASH  
SUPPRESSOR

ORIGINAL DATE OF DRAWING 8 NOV 54		SUBMITTED	
DRAFTSMAN C. L. B.	CHECKER	ENGINEER	ENGINEER
TRACER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER
ENGINEER	CHECKER	ENGINEER	ENGINEER

R.M.H.

NOTES: WHEN GOVERNMENT DRAWINGS SPECIFICATIONS OR OTHER DATA ARE USED FOR ANY PURPOSE OTHER THAN IN CONNECTION WITH A DEFINITELY RELATED GOVERNMENT PROCUREMENT, THE UNITED STATES GOVERNMENT THEREBY INCURS NO RESPONSIBILITY AND ANY OBLIGATION WHATSOEVER. THE FACT THAT THE GOVERNMENT MAY HAVE FURNISHED OR IN ANY WAY SUPPLIED THE SAID DRAWINGS, SPECIFICATIONS OR OTHER DATA IS NOT TO BE CONSTRUED BY THE USER OR OTHERS AS IN ANY MANNER ENDORSING THE HOLDER OR ANY RIGHTS OR PERMISSION TO MANUFACTURE, USE OR SELL ANY INVENTED INVENTION THAT MAY IN ANY WAY BE RELATED THERETO.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
C		8 NOV 63	
D	REDRAWN & REVISED SEE EO SA 274-41	2 NOV 64	<i>[Signature]</i>
E	(1) SEE EO SA 29262	18 MAY 66	<i>[Signature]</i>
F	(1-2) SEE EO 82048	11 MAR 68	<i>[Signature]</i>
G	(1) SEE EO HRD 92078-2	25 JUN 69	<i>[Signature]</i>
H	SEE EO HRD 02138	71 FEB 75	<i>[Signature]</i>
J	(3) SEE ERR HQ 40681	10 FEB 75	<i>[Signature]</i>
K	NOR W8S2022/79-03-26	79-04-01 SA R.H.H.	

WIRE DIAMETER ----- .0400 ± .0005  
 COIL DIAMETER ( O. D. ) ----- .1525 ± .0025  
 FREE LENGTH ----- .925 REF  
 TOTAL COILS ----- 17 REF  
 DIRECTION OF HELIX ----- R. H.  
 LOAD AT COMPRESSED LENGTH OF .808 ----- 24.00 LB ± 2.44 LB  
 LOAD AT COMPRESSED LENGTH OF .765 ----- 32.81 LB ± 3.31 LB  
 SPRING RATE ----- 204.8 LB/IN REF  
 SOLID LENGTH ----- .741 MAX  
 TYPE OF ENDS ----- OPEN ENDS NOT GROUND  
 MANUFACTURE IN ACCORDANCE WITH MIL-S-13572, TYPE I, GRADE A. (F2)

#### NOTES:

- HOLE DIA INTO WHICH SPRING FITS FREELY .160 MIN.
- ROD DIA OVER WHICH SPRING SLIDES FREELY MAX.
- HEAT TREATMENT: STRESS RELIEVE AT 425 °F. TO 445 °F. FOR 30 MIN, AFTER COILING.
- LOAD REQUIREMENTS SHALL APPLY SPRING HAS BEEN COMPRESSED TO SOLID LENGTH 3 TIMES.

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND  
 DOVER, NEW JERSEY 07801

CODE IDENT NO.  
 19200

PART NO. 7267041

(USED WITH LATCH, MAGAZINE 7267032) (E1)

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 4 OCT 54		DEPT OF THE ARMY ROCK ISLAND ARSENAL ROCK ISLAND ILL 61201	
YP		RIFLE, M21	TOLERANCES ON DECIMALS ±	DRAFTSMAN	CHECKER	SPRING, HELICAL, COMPRESSION	
TS		RIFLE, M14 NM	FRACTIONS ± ANGLES ±	A. U. A.	E. F. K.		
EL 2	C 7790196	RIFLE, M14	MATERIAL: STEEL WIRE, SPEC QQ-W-470	TRACER	CHECKER WBS		
RA			HEAT TREATMENT SEE NOTE 3	ENGINEER	ENGINEER		
BH		NEXT ASSY USED ON APPLICATION	FINAL PROTECTIVE FINISH LUB OIL, SPEC VV-L-800	SUBMITTED		CODE IDENT NO.	DWG SIZE
RH		DO NOT APPLY PART NO		APPROVED		19204	B
				V. A. [Signature]		SCALE	UNIT WT
						SHEET	OF

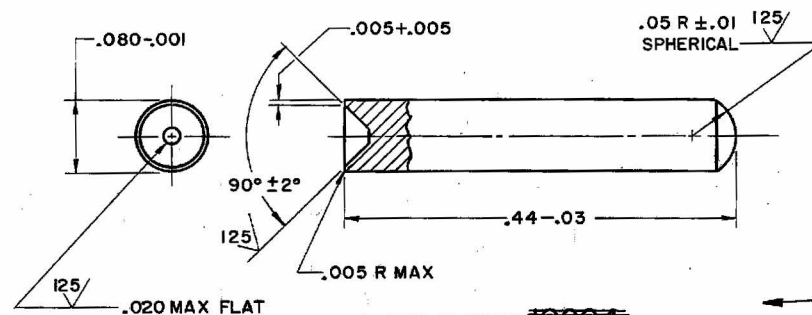
NOTES:

1. FINISH <sup>63</sup>/ EXCEPT AS NOTED.
2. MATERIAL: TOOL STEEL, FED. SPEC QQ-T-570: DRILL ROD, CLASS O1, ANNEALED. (C1)
3. MIL-W-13855 SHALL APPLY. (G)

B7267042

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
A	REDRAWN AND REVISED		
	SEE EO SA 24529	10 JUL 59	R. Henry
B 2	SEE EO SA 26974	21 AUG 63	R. Henry
C	(1-3) SEE EO SA 29262	18 MAY 68	N. S. S. S.
D	SEE EO 82048	11 MAR 68	R. Henry
E	(1) SEE EO HRD 92078-2	25 JUN 68	R. Henry
F	SEE EO HRD 02138	71 FEB 70	R. Henry
G	NOR W8S2022/79-03-26	79-04-01	R. Henry
H	NOR W4S2051/840824 ECPW5S2069 /851223	860121	R. Henry

(B)



ORIGINAL FSCM NO. 19205

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

(G)

(E1)

(B)

(C3)

(C2)

CODE IDENT NO. 19204

PART NO. 7267042

F9352636 RIFLE, M4NM		F7790191 RIFLE, M14		PHYSICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED		ORIGINAL DATE OF DRAWING 4 AUG 54	
				YP		DIMENSIONS ARE IN INCHES		DRAFTSMAN M.L.F. CHECKER E.S.R.	
				TS		TOLERANCES ON		TRACER J.M.S. CHECKER E.S.R.	
				EL2		FRACTIONS DECIMALS ANGLES		DRAWN J.M.S. CHECKER E.S.R.	
				RA				SUBMITTED	
				SH		MATERIAL		APPROVED BY DESIGN BY THE	
				RH		SEE NOTE 2		CHIEF OF CORPS	
						HEAT TREATMENT		R. S. Henry	
						NONE		DND CORPS	
						FINAL PROTECTIVE FINISH		A. J. Lynch	
						FINISH 5.3.1.2 OF MIL-STD-171		CORPS	

PIN,  
RETAINING

DEPT OF THE ARMY  
US ARMY WEAPONS  
COMMAND  
ROCK ISLAND, ILL 61201

DWG  
SIZE  
B  
7267042  
SHEET 1 OF 1

SCALE 10 / 1 UNIT WT

RNH



1178

NOTES:

1. DWG B7266102 APPLIES.
2. FINISH  $\frac{63}{\sqrt{}} \frac{1}{\sqrt{}}$  EXCEPT AS NOTED.
3. ALL EDGES SHALL BE BROKEN .005+.010 UNLESS OTHERWISE SPECIFIED.
4. MATERIAL: STEEL, FED SPEC QQ-S-624: 8645 SPHEROIDIZED, AUSTENITE GRAIN SIZE 7 OR FINER AS QUENCHED FROM 1550° F. FED TEST METHOD STD NO. 151, METHOD 311, PROCEDURE F.
5. HEAT TREATMENT: HEAT TO 1500°-1550° F. OIL QUENCH. TEMPER 1 HOUR AT HEAT TO HARDNESS SPECIFIED. NO DECARBURIZATION PERMISSIBLE.

SECTION C-C

SECTION B-B

SECTION A-A

DETAIL D  
SCALE 20:1

SECTION E-E  
SCALE 4/1

ALTERNATIVE DESIGN

EDGES SHALL BE BROKEN TO .02 R + .01 AND SHALL BE FREE FROM NICKS AND IRREGULARITIES

NOTE: THIS LENGTH MUST NEVER EXCEED .217 OR BE LESS THAN .200  
ADJUST TOLERANCES ON DIMENSIONS  
⊗ TO MEET THIS REQUIREMENT

REMOVE LATERAL AND CIRCUMFERENTIAL LINES FROM SURFACES

-A- AND A TO BE ON A COMMON CENTER. THE SECTION BETWEEN SHALL NOT BE MORE THAN .003 ECCENTRIC (.006 TIR)

SYN	DESCRIPTION	DATE	APPROVAL
E2	SEE EO SA 25711	1 JUN 60	
D2	SEE EO SA 25589	12 APR 60	
C4	SEE EO SA 24866	23 OCT 58	
S	REDRAWN AND REVISED WAS	10 JUL 58	
C	SIZE SEE EO SA 24529		
A		20 OCT 54	

PHYSICAL PROPERTIES	APPLICATION	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	ORIGINAL DATE OF DRAWING
YP		TOLERANCES ON DECIMALS ± .01	26 AUG 54
TS		ANGLES ± 1°	
EL 2	C 7790187 RIFLE M14	FRACTIONS ± 1/64	DRAFTSMAN C. L. B. CHECKER
RA	SEE ENGRG RECORDS		TRACER S. X. CHECKER
BN		MATERIAL SEE NOTE 4	ENGINEER R. S. HENRY
BN		HEAT TREATMENT SEE NOTE 5	ENGINEER
BN	C39T044	DO NOT APPLY PART NO.	APPROVED BY CHIEF OF THE
		FINISH NO 5.31 OF MIL-STD-171	ORD CORPS

ORD PART NO. 7267043

PIN,  
FIRING

SPRINGFIELD ARMORY  
ORDNANCE CORPS  
DEPT OF THE ARMY  
SPRINGFIELD 1, MASS.

7267043

R.M.H.



NOTES:

1. FINISH 125 EXCEPT AS NOTED.
2. ALL EDGES SHALL BE BROKEN .010 MAX UNLESS OTHERWISE SPECIFIED.
3. MATERIAL: STEEL, CORROSION RESISTING FED SPEC QQ-S-763; CLASS 420, CONDITION A EXCEPT: COPPER 0.50% MAX.
4. HEAT TREATMENT: HEAT AT 1800°-1850°F. AIR QUENCH. TEMPER 30 MINUTES AT A MINIMUM TEMPERATURE OF 850°F. TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
5. MIL-W-13855 SHALL APPLY.

SECTION B-B

SECTION C-C

SECTION A-A

ALTERNATIVE METHOD

CURRENT DESIGN ACTIVITY FSCM NO.19200  
US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

PHYSICAL PROPERTIES		TOLERANCES ON DIMENSIONS		HEAT TREATMENT	
TEMP		UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES		TEMPERATURE	
TEMP		UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES		TEMPERATURE	
TEMP		UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES		TEMPERATURE	
TEMP		UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES		TEMPERATURE	

N	ERR Z921171AF	991010	
M	(ECP G952024/990516)		
L	NOR W252025/18410104020		
K	SEE E.O. 12812		
J	SEE E.O. 12812		
I	SEE E.O. 12812		
H	SEE E.O. 12812		
G	SEE E.O. 12812		
F	SEE E.O. 12812		
E	SEE E.O. 12812		
D	SEE E.O. 12812		
C	SEE E.O. 12812		
B	REDRAWN AND REVISED		
A	SEE E.O. 12812		

PISTON

SPRINGFIELD  
ARMORY  
SPRINGFIELD, MA

CODE IDENT NO.19205

7267047

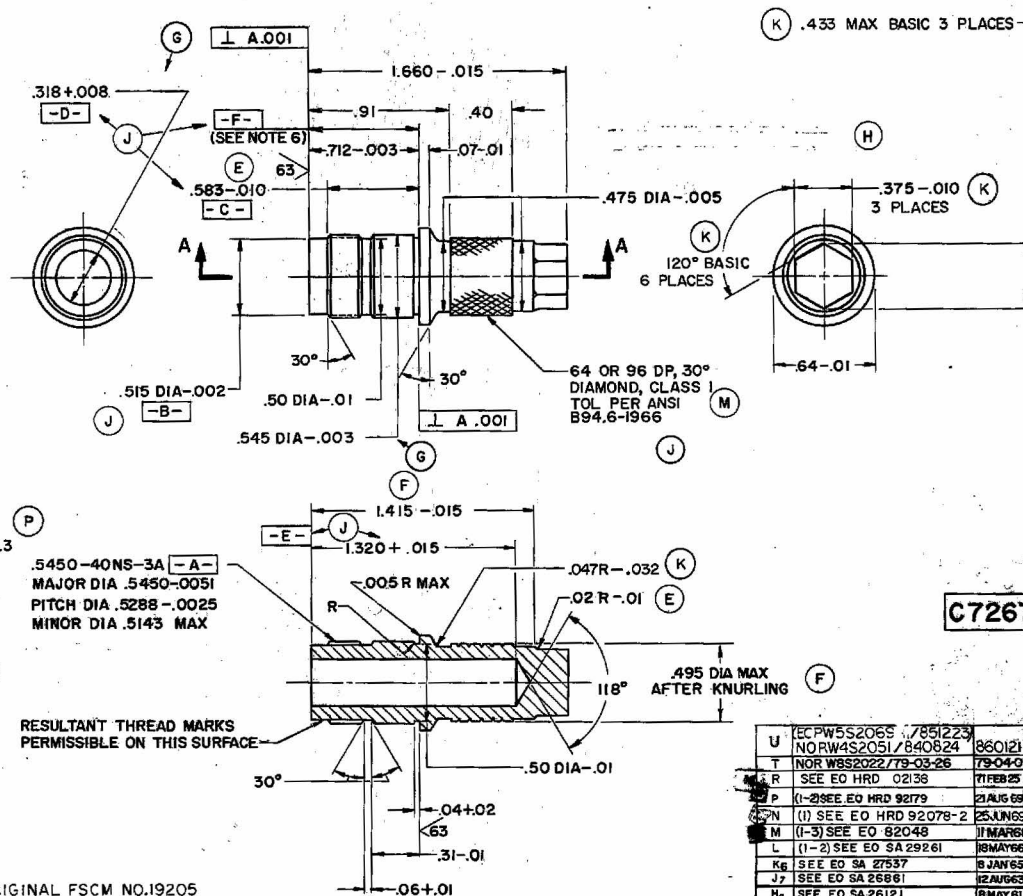
D 7267047

B 7267047

A 7267047

## NOTES:

1. FINISH 125/ EXCEPT AS NOTED.
2. ALL EDGES SHALL BE BROKEN .005 + .010 UNLESS OTHERWISE SPECIFIED.
3. DIMENSION  $\boxed{-C-}$  APPLIES AT MAX DIA  $\boxed{-B-}$
4. MATERIAL: STEEL, CORROSION RESISTING, SPEC ASTM A484, CLASS 416 OR 416Se. MATERIAL SHALL BE CAPABLE OF MEETING THE ROCKWELL C32 TO C40 HARDNESS REQUIREMENT AFTER AIR QUENCHING FROM 1800°F TO 1850°F AND TEMPERING AT 450°F MINIMUM, FOR ONE HOUR.
5. HEAT TREATMENT: HEAT TO 1800° TO 1850°F. OIL QUENCH. TEMPER 1 HOUR AT HEAT TO ROCKWELL SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
6. FINAL PROTECTIVE FINISH: FINISH NO. 3.3.2 OR 3.3.3 OF MIL-STD-171 WITH SUPPLEMENTARY PRESERVATIVE CONFORMING TO VV-L-800. THREADS SHALL BE FREE OF PROTECTIVE FINISH. PROTECTIVE FINISH IS OPTIONAL ON THE FOLLOWING SURFACES:
  - a. EXTERNAL SURFACES WITHIN LENGTH  $\boxed{-F-}$  EXCEPT THREADS.
  - b. SURFACES  $\boxed{-D-}$  AND  $\boxed{-E-}$
7. MIL-W-13855 SHALL APPLY.



ORIGINAL FSCM NO.19205

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

## SECTION A-A

CODE IDENT NO. 19204  
PART NO. 7267053

PHYSICAL PROPERTIES	J9386974	RIFLE, M14NM
TP		
TS		
SL 2	F7267000	RIFLE, M14
SA		
BN		
RH	C32-40	
DO NOT	APPLY PART NO.	
DO	APPLY PART NO.	

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES	
TOLERANCES ON	DECIMALS $\pm .01$
ANGLES $\pm 1^\circ$	FRACTIONS $\pm$
MATERIAL	SEE NOTE 4
HEAT TREATMENT	SEE NOTE 5
FINAL PROTECTIVE FINISH	SEE NOTE 6

ORIGINAL DATE OF DRAWING	4 OCT 54
DRAFTSMAN C.L.B.	CHECKED
TRACER	CHECKED
ENGINEER	CHECKED
APPROVED BY	R. S. Henry
APPROVED BY	A. J. Bouch

PLUG, GAS CYLINDER
SCALE 2/1
UNIT WT

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS 61201
DWG NO. 7267053
SHEET 1 OF 1

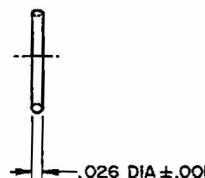
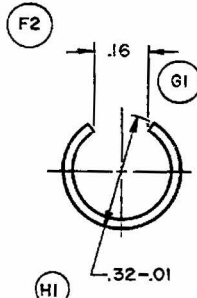
U	ECPW552065 / 7851223	860121	
T	NORW4S2051 / 840824	79-04-01	SA 11/11
R	SEE EO HRD 02136	71FEB25	SA 11/11
P	(1-2) SEE EO HRD 92179	21AUG 68	SA 11/11
PN	(1) SEE EO HRD 92078-2	25JUN 68	SA 11/11
M	(1-3) SEE EO 82048	11MAY 68	SA 11/11
L	(1-2) SEE EO SA 29261	18MAY 66	SA 11/11
Kg	SEE EO SA 27537	6JAN 65	SA 11/11
J7	SEE EO SA 26861	12AUG 63	SA 11/11
H2	SEE EO SA 26121	6MAY 61	SA 11/11
G*	SEE EO SA 25966	23DEC 60	SA 11/11
F*	SEE EO SA 25598	18MAR 60	SA 11/11
E*	SEE EO SA 25019	18MAY 59	SA 11/11
D	REDRAWN AND REVISED	10JUL 58	SA 11/11
C	SEE EO SA 24929	4SEP 58	SA 11/11
DTM			

00 FORM 1 APR 64 1175

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NOTES:

1. MIL-W-13855 SHALL APPLY.
2. ENDS SHALL BE FREE OF BURRS.
3. RING MUST BE ABLE TO CLOSE TO A .268 O.D. WITHOUT A PERMANENT SET AND WITHOUT THE ENDS TOUCHING.
4. RING SHALL BE FREE FROM SCRATCHES, SPLITS, CRACKS, SEAMS, NICKS, DIE-MARKS AND OTHER INJURIOUS DEFECTS.



DISTRIBUTION STATEMENT A  
APPROVED FOR PUBLIC RELEASE. DISTRIBUTION IS UNLIMITED

	RIFLE, M14
C7790186	RIFLE, M14-NM
D7342737	RIFLE, M14
	.30R-M14-MIC
	8 MID
	NM-.30R-M14
D7790386	RIFLE, M14-NM
	HEAT TREAT
	USED ON
	APPLICATION
DO NOT	APPLY PART NO.
USE	-48-0500000000

PHYSICAL PROPERTIES
TP
TS
BM
RM

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON FRACTIONS DECIMALS ANGLES
±.02
MATERIAL:
STEEL WIRE, ASTM A228
HEAT TREATMENT: STRESS RELIEVE 30 MINUTES AT 425°F.
FINAL PROTECTIVE FINISH:
MIL-L-3150

ORIGINAL DATE OF DRAWING
17 SEP 54
DRAWN BY
CHECKED BY
THICK BY
DATE
SUBMITTED
APPROVED BY
DATE

CODE IDENT NO. 19205  
PART NO. 7267059

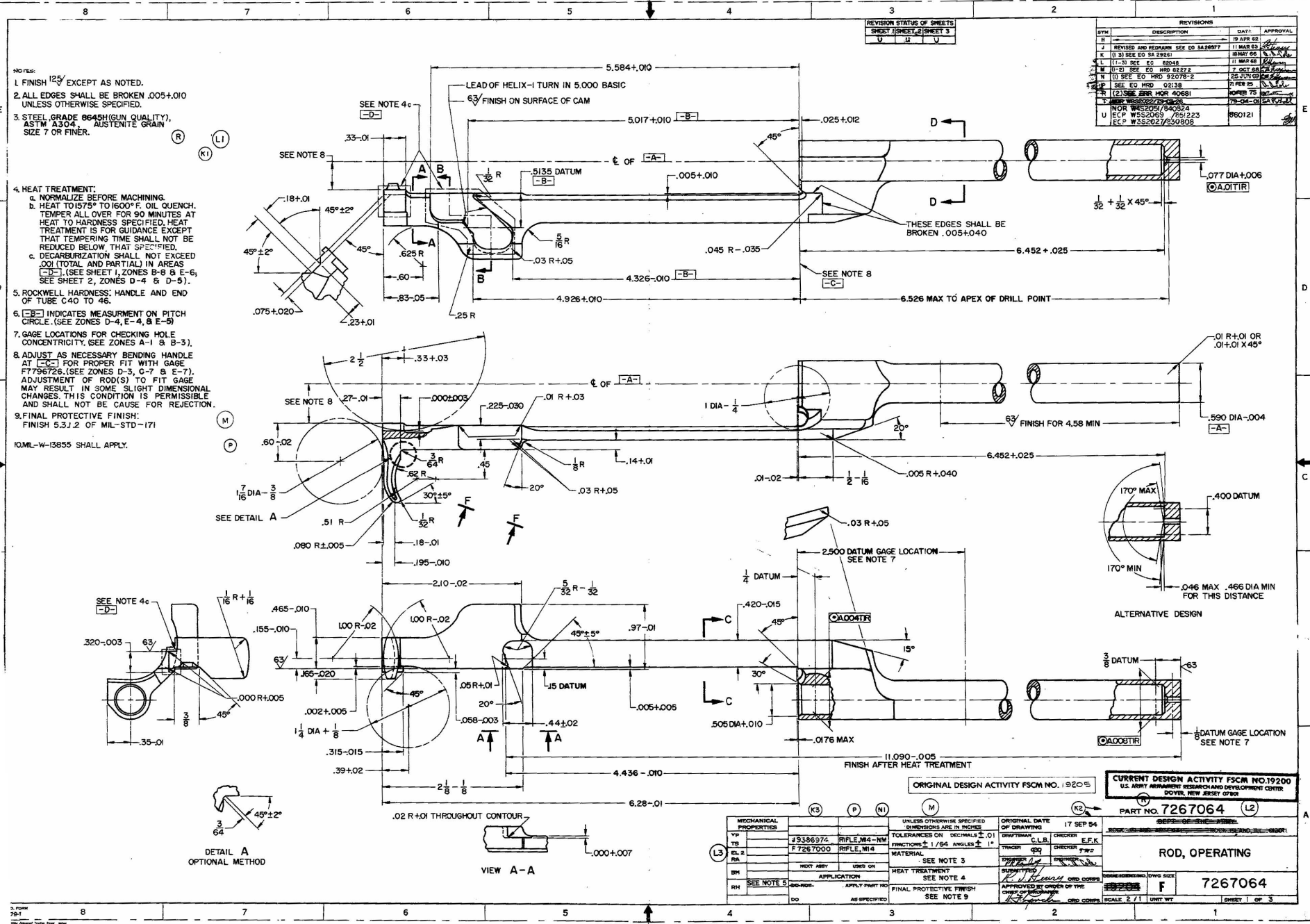
RING,  
RETAINING

SPRINGFIELD ARMOY  
U.S. ARMY WEAPONS  
COMMAND  
SPRINGFIELD, MASS.

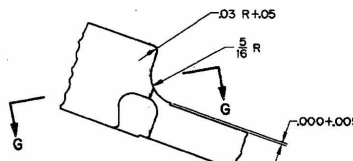
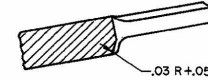
7267059  
B  
SHEET 1 OF 1

SYMBOL	REVISIONS	DATE	APPROVAL
C		10 JUL 58	
D	REDRAWN AND REVISED WAS A SIZE.	17 SEP 62	
	SEE EO SA 26417		
E	(1-2) SEE EO SA 29262	18 MAY 66	
F	(1-2) SEE EO RIA-14067	3-21-67	
G	(1-3) SEE EO-82023	20 FEB 68	
H	(1) SEE EO HRD 92078-2	25 JUNE 68	
J	SEE EO HRD 02138	7 FEB 25	
K	NOR W8S2022/79-03-26	79-04-01	
L	NORW4S2051 / 840824 ECP W5S2069 / 851223	860121	
M	NORG2S2038/921021 (ECPG2S2042/ 921021)	921230	





CODE-TO-BOARD	DWG SIZE	7267064
<del>1020</del>	F	
SCALE 2/1	UNIT WT	SHEET 2 OF 3



VIEW F-F

SECTION C-C

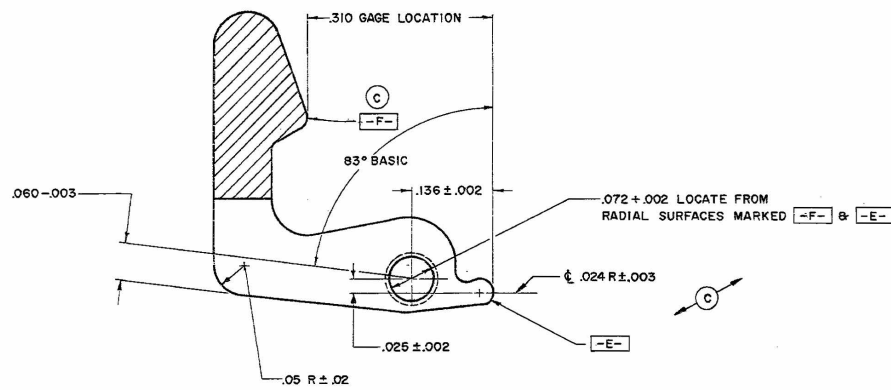
(K2)		(N1)		PART NO. 7267064 (L2)		(R)	
MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING		17 SEP 54	
				17 SEP 54			
TENSILE		TOLERANCES ON DIMENSIONS		DRAWN BY		CHECKED BY	
THICKNESS		FRACTIONS ±		THICKNESS		CHECKED BY	
RADIUS		ANGLES ±		TRACER		CHECKED BY	
FINISH		MATERIAL		DATE		DATE	
NEXT ASST		USE ON		SEE SHEET 1		SEE SHEET 1	
APPLICATION		HEAT TREATMENT		APPROVED BY		DATE	
APPLY PART NO.		SEE SHEET 1		APPROVED BY		DATE	
DO AS NOTED		FINAL PROTECTIVE FINISH		SCALE 2/1		UNIT WT	
		SEE SHEET 1		SCALE 2/1		UNIT WT	



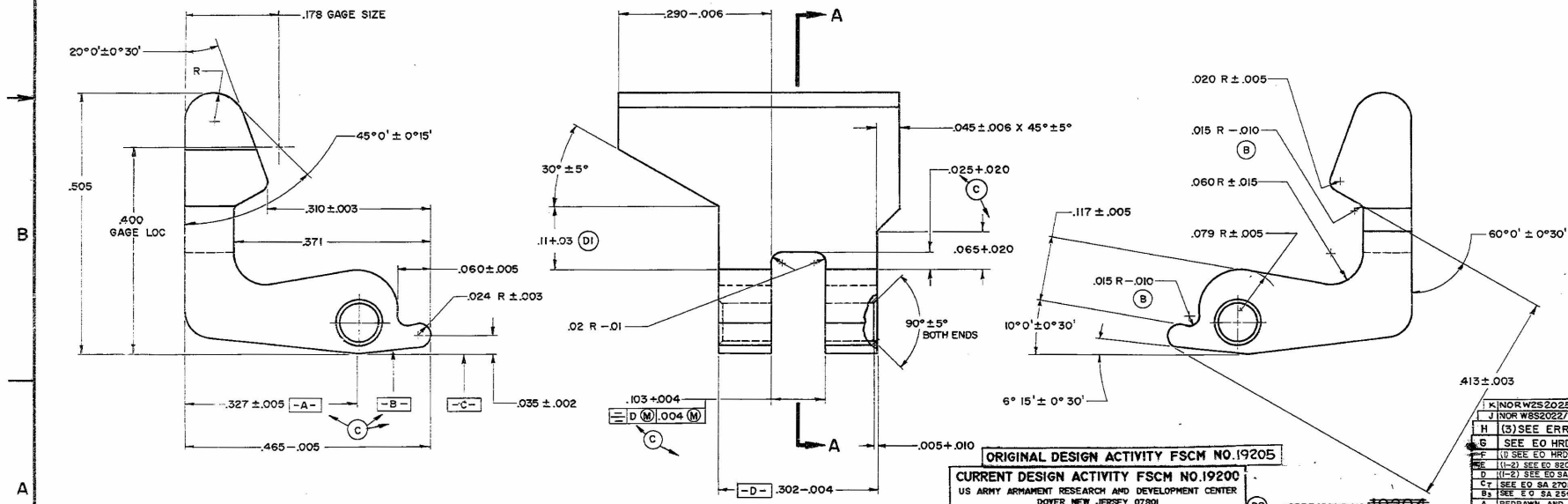
PDC

NOTES:

1. FINISH  $\sqrt{\text{ALL OVER}}$  (H)
2. ALL EDGES SHALL BE BROKEN .005 ± .010 UNLESS OTHERWISE SPECIFIED.
3. -A- LOCATION OF INTERSECTION OF SURFACE -B- AND LINE -C-
4. MATERIAL: STEEL SPEC ASTM A304, A322, A334, 8620 EXCEPT SULPHUR .035% MAX (RESULPHURIZED) AUSTENITE GRAIN SIZE 5-8.
5. HEAT TREATMENT: CARBURIZE AT 1575°-1600°F. FROM .010 TO .015 DEPTH. OIL QUENCH. TEMPER 20 MINUTES AT 350°F. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED. THE USE OF STRAIGHT CYANIDE BATH OR CARBO-NITRIDING PROCESSES SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF THE CONTRACTING OFFICER.
6. MIL-W-13855 SHALL APPLY. (G)



SECTION A-A



ORIGINAL DESIGN ACTIVITY FSCM NO.19205  
CURRENT DESIGN ACTIVITY FSCM NO.19200  
US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

PHYSICAL PROPERTIES	DESIGNATION	REVISIONS
ITEM	FILE NO.	REVISION
1	7267090	1
2	7267090	2
3	7267090	3
4	7267090	4
5	7267090	5
6	7267090	6
7	7267090	7
8	7267090	8
9	7267090	9
10	7267090	10

ORIGINAL DATE OF DRAWING 10 AUG 54  
DRAWN BY H.M.F. CHECKED BY  
THICK BY ENGINEER C.D.E.  
ENGINEER BY ENGINEER D.A.B.  
SUBMITTED BY  
APPROVED BY OFFICE OF THE  
CHIEF OF STAFF  
R.D. Henry  
10 AUG 54  
SCALE 10/1 UNIT W.T.  
RMH

REVISIONS

NO.	DESCRIPTION	DATE	APPROVAL
1	SEE E.O. 128048		
2	SEE E.O. 128048		
3	SEE E.O. 128048		
4	SEE E.O. 128048		
5	SEE E.O. 128048		
6	SEE E.O. 128048		
7	SEE E.O. 128048		
8	SEE E.O. 128048		
9	SEE E.O. 128048		
10	SEE E.O. 128048		

DEPARTMENT OF THE ARMY  
ROCK ISLAND ARSENAL  
ROCK ISLAND, ILL. 61201

7267070



NOTES: WHEN GOVERNMENT DRAWINGS SPECIFICATIONS OR OTHER DATA ARE USED FOR ANY PURPOSE OTHER THAN IN CONNECTION WITH A DEFINITELY RELATED GOVERNMENT PROCUREMENT, THE UNITED STATES GOVERNMENT THEREBY INCURS NO RESPONSIBILITY, NOR ANY OBLIGATION WHATSOEVER, AND THE FACT THAT THE GOVERNMENT MAY HAVE FORMULAS, SPECIFICATIONS OR OTHER DATA IS NOT TO BE CONSIDERED BY INDICATION OR OTHER, USE AS IN ANY OTHER LICENSING, OR CONVEYING ANY RIGHTS OR PERMISSION TO MANUFACTURE, USE, OR SELL ANY PATENTED INVENTION THAT MAY IN ANY WAY BE RELATED THEREIN.

WIRE DIAMETER ----- .0180 ± .0003  
 COIL DIAMETER ( O. D. ) ----- .1225 ± .0025  
 FREE LENGTH ----- .424 REF  
 TOTAL COILS ----- 9 REF  
 DIRECTION OF HELIX ----- OPTIONAL  
 LOAD AT COMPRESSED LENGTH OF .350 ----- 1.12 LB ± .31 LB  
 LOAD AT COMPRESSED LENGTH OF .240 ----- 2.75 LB ± .56 LB  
 SPRING RATE ----- 14.7 LB/IN REF  
 SOLID LENGTH ----- .183 MAX  
 TYPE OF ENDS ----- OPEN ENDS NOT GROUND  
 MANUFACTURE IN ACCORDANCE WITH MIL-S-13572, TYPE I, GRADE A.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
F		9 APR 62	
G	REDRAWN & REVISED SEE EO SA 27441	2 NOV 64	<i>R. Henry</i>
H	(1) SEE EO SA 29262	18 MAY 66	<i>R. Henry</i>
J	(1-2) SEE EO 82048	11 MAR 68	<i>R. Henry</i>
K	(1) SEE EO HRD 92078-2	25 JUN 69	<i>R. Henry</i>
L	SEE EO HRD 02138	71 FEB 75	<i>R. Henry</i>
M	(3) SEE ERR HOR 40681	10 FEB 75	<i>R. Henry</i>
N	NOR WBS2022/79-03-26	79-04-01	<i>R. Henry</i>
P	NORW4S2051/840824 ECPW5S2069 /851223)	860121	<i>R. Henry</i>

# NOTES:

- HOLE DIA INTO WHICH SPRING FITS FREELY .130 MIN.
- ROD DIA OVER WHICH SPRING SLIDES FREELY MAX.
- HEAT TREATMENT: STRESS RELIEVE AT 425 °F. TO 445 °F. FOR 30 MIN, AFTER COILING.
- FINAL PROTECTIVE FINISH: FINISH 3.3.1 OF MIL-STD-171 WITH SUPPLEMENTARY PRESERVATIVE CONFORMING TO SPEC VV-L-800.
- LOAD REQUIREMENTS SHALL APPLY AFTER SPRING HAS BEEN COMPRESSED TO SOLID LENGTH 3 TIMES.

(K1) (M) (USED WITH STOP, BOLT-7267034)

(H1) ORIGINAL FSCM NO.19205

PART NO. 7267074

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
 U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
 DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 17 SEP 54	
YP	9386974	RIFLE, M14, NM	TOLERANCES ON DECIMALS ±	DRAFTSMAN J.L.T.	CHECKER E.P.S.
TS	F7267000	RIFLE, M14	FRACTIONS ± ANGLES ±	TRACER J.L.T.	CHECKER WNS
EL 2			MATERIAL: STEEL, WIRE, SPEC QQ-W-470	ENGINEER <i>R. Henry</i>	ENGINEER <i>R. Henry</i>
RA			HEAT TREATMENT	SUBMITTED	
BH	NEXT ASSY	USED ON	SEE NOTE 3	APPROVER <i>R. Henry</i>	
RH	DO NOT	APPLY PART NO	FINAL PROTECTIVE FINISH		
	AS-SPECIFIED		SEE NOTE 4		

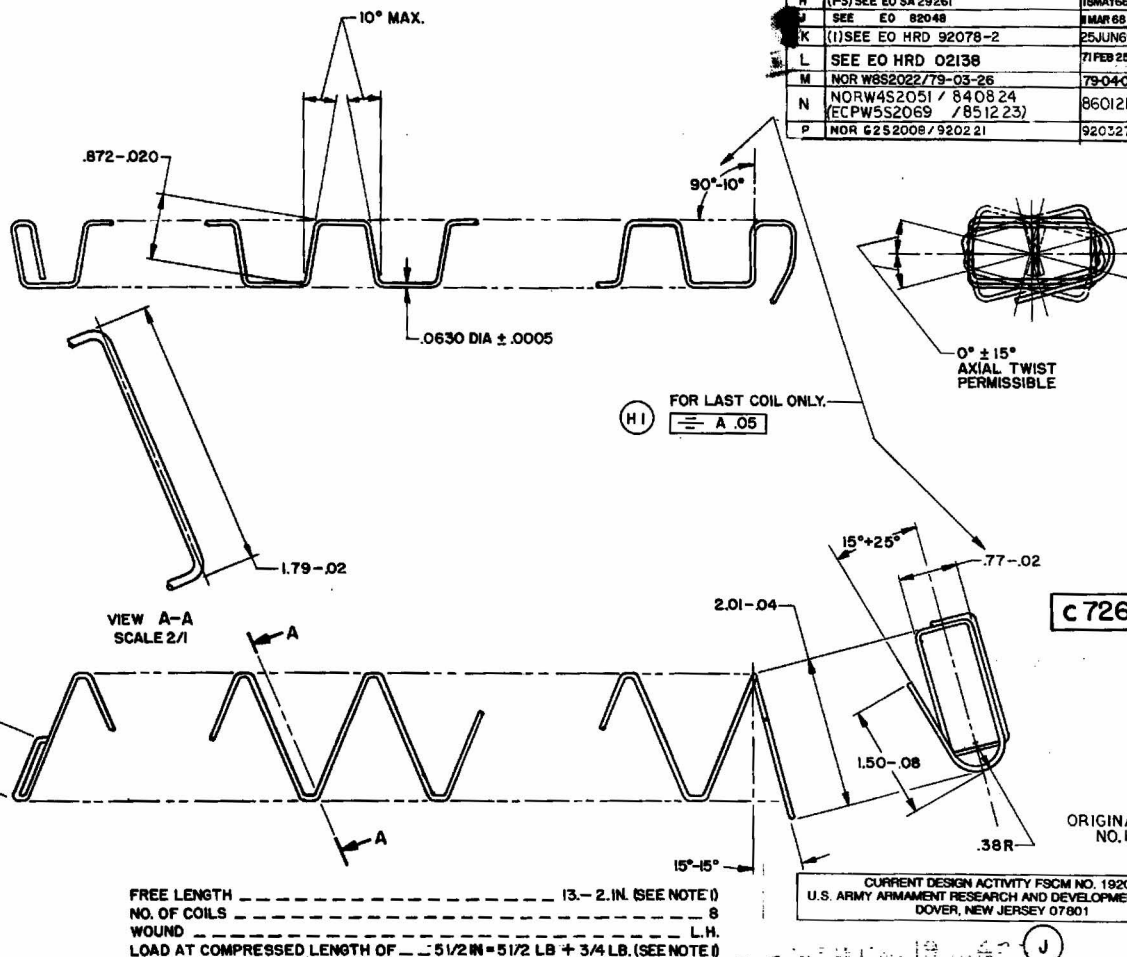
SPRING, HELICAL, COMPRESSION

CODE IDENT NO.	DWG SIZE	
19204	B	7267074
SCALE	UNIT WT	SHEET 1 OF 1



**NOTES:**

1. SPRINGS SELECTED FOR INSPECTION SHALL BE COMPRESSED TO A HEIGHT OF 11/16 IN. THREE TIMES PRIOR TO INSPECTION.
2. SPRINGS SHALL BE FREE FROM SCRATCHES, SPLITS, LAPS, CRACKS, SEAMS, NICKS, DIE MARKS, AND OTHER INJURIOUS DEFECTS.
3. MIL-W-13855 SHALL APPLY.



REVISIONS			
SYN	DESCRIPTION	DATE	APPROVAL
F		15 JAN 80	
G	REDRAWN AND REVISED-SEE EO SA28529	21 NOV 79	<i>W. J. ...</i>
H	(1-3) SEE EO SA 29261	18 MAY 78	<i>W. J. ...</i>
J	SEE EO 82048	16 MAR 68	<i>W. J. ...</i>
K	(1) SEE EO HRD 92078-2	25 JUN 79	<i>W. J. ...</i>
L	SEE EO HRD 02138	71 FEB 25	<i>W. J. ...</i>
M	NOR W852022/79-03-26	79-04-01	<i>W. J. ...</i>
N	NORW452051 / 840824 ECWPW52069 / 851223)	860121	<i>W. J. ...</i>
P	NOR G252008 / 9202 21	920227	<i>W. J. ...</i>

c 7267078

ORIGINAL FSCM  
NO. 19205

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

PART NO. 7267078

PHYSICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TP		TOLERANCES ON DECIMALS 0.01	
TS		ANGLES ± 1° FRACTIONS ± 1/64	
EL 2	D77901B3	MATERIAL	
BA	RIFLE, M14	STEEL, WIRE, PER ASTM A 228	
SH	HEAT TREATMENT	HEAT TREATMENT AFTER FORMING, STRESS RELIEVE 30 MIN AT 400°F ± 25°F.	
SE	APPLICATION	FINAL PROTECTIVE FINISH	
	DO NOT	LUB OIL, SPEC VV-L-800	
	APPLY PART NO.		

ORIGINAL DATE OF DRAWING		18 OCT 5	
DRAFTSMAN G.V.S		CHECKER	EPS
TRACER GSG		CHECKER	EPS
ENGINEER <i>[Signature]</i>		SIGNATURE <i>[Signature]</i>	
SUBMITTED <i>[Signature]</i>			
O&G CORP.			
APPROVED BY ORDER OF THE CHIEF OF CRANES <i>[Signature]</i>			

SPRING,  
MAGAZINE

**SPRINGFIELD  
ARMORY  
SPRINGFIELD, MA**

DWG SIZE	7267078		
C	SHEET	OF	

**DISTRIBUTION STATEMENT A**  
**APPROVED FOR PUBLIC RELEASE, DISTRIBUTION IS UNLIMITED.**

SCALE 1/1	UNIT W
-----------	--------

NOTES: WHEN GOVERNMENT DRAWINGS SPECIFIC DATA OR OTHER DATA ARE USED FOR ANY PURPOSE OTHER THAN IN CONNECTION WITH A DEFINITELY RELATED GOVERNMENT PROCUREMENT OPERATION, THE UNITED STATES GOVERNMENT THEREBY INCURS NO RESPONSIBILITY FOR ANY OBLIGATION WHATSOEVER. THE FACT THAT THE GOVERNMENT MAY HAVE FORMULATED THE DATA OR IN ANY WAY SUPPLIED THE SAID DRAWINGS BY CERTIFICATION OR OTHERWISE AS IN ANY MANNER LICENSING THE HOLDER OR ANY OTHER PERSON OR CORPORATION OR CONCEIVING ANY RIGHTS OF PERMISSION TO MANUFACTURE, USE, OR SELL ANY PATENTED INVENTION THAT MAY IN ANY WAY BE DERIVED THEREFROM.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
D		19 APR 62	
E	REDRAWN AND REVISED, SEE EO SA 27441	2 NOV 64	<i>R. J. Henry</i>
F	(1) SEE EO SA 29261	18 MAY 66	<i>R. J. Henry</i>
G	(1-2) SEE EO 82048	11 MAR 68	<i>R. J. Henry</i>
H	(1) SEE EO HRD 92078-2	25 JUN 69	<i>R. J. Henry</i>
J	SEE EO HRD 02138	7 FEB 75	<i>R. J. Henry</i>
K	(3) SEE ERR HQR 40681	10 FEB 75	<i>R. J. Henry</i>
L	NOR WBS2022/79-03-26	79-04-01	<i>R. J. Henry</i>
M	NOR WBS2051/840824 ECP WBS2069 /851223	860121	<i>R. J. Henry</i>

WIRE DIAMETER ----- .054 ± .001  
 COIL DIAMETER ( O. D. ) ----- .4575 ± .0025  
 FREE LENGTH ----- 15.23 REF  
 TOTAL COILS ----- 104 REF  
 DIRECTION OF HELIX ----- R. H.  
 LOAD AT COMPRESSED LENGTH OF 10.97 ----- 8.13 LB ± .81 LB  
 LOAD AT COMPRESSED LENGTH OF 6.42 ----- 17.00 LB ± 1.69 LB  
 SPRING RATE ----- 1.95 LB/IN REF  
 SOLID LENGTH ----- 5.78 MAX  
 TYPE OF ENDS ----- CLOSED ENDS GROUND  
 MANUFACTURE IN ACCORDANCE WITH MIL-S-13572, TYPE I, GRADE B.

#### NOTES:

- HOLE DIA INTO WHICH SPRING FITS FREELY .474 MIN.
- ROD DIA OVER WHICH SPRING SLIDES FREELY .340 MAX.
- HEAT TREATMENT: AGE AT 900°F FOR 1 HOUR. AIR COOL. HEAT SET 700°F FOR 20 MINUTES WITH SPRING COMPRESSED TO 5.9 TO 6.0 INCHES.
- LOAD REQUIREMENTS SHALL APPLY AFTER SPRING HAS BEEN COMPRESSED TO SOLID LENGTH 3 TIMES.

ORIGINAL FSCM NO. 19205

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
 U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
 DOVER, NEW JERSEY 07801

(HI) (FI) (USED WITH ROD, OPERATING - 7267064)

(J)

(G2)

PART NO. 7267079

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 17 SEP 54		<del>DEPT OF THE ARMY</del> <del>ROCK ISLAND ARSENAL</del> <del>ROCK ISLAND, ILL. 61204</del>	
YP	J9386974	RIFLE, M14-NM	TOLERANCES ON DECIMALS ±	DRAFTSMAN R.S.K.	CHECKER J.P.	<b>SPRING, HELICAL, COMPRESSION</b>	
TS	F7267000	RIFLE, M14	FRACTIONS ± ANGLES ±	TRACER	CHECKER W.H.S.		
EL 2			MATERIAL: WIRE, STEEL, CORROSION RESISTANT, MIL-W-46078	ENGINEER	ENGINEER		
RA			HEAT TREATMENT SEE NOTE 3	SUBMITTED			
BH		NEXT ASSY USED ON	FINAL PROTECTIVE FINISH NONE	APPROVED		CODE-IDENT NO. 19204	DWG SIZE B
RH		DO NOT APPLY PART NO				SCALE	UNIT WT
							SHEET 1 OF 1

SWESP Form 467  
 6 MAR 63

NOTES: WHEN GOVERNMENT DRAWINGS SPECIFIC DATA OR OTHER DATA ARE USED FOR ANY PURPOSE OTHER THAN IN CONNECTION WITH A DEFINITELY RELATED GOVERNMENT PROCUREMENT OPERATION, THE UNITED STATES GOVERNMENT THEREBY INCURS NO RESPONSIBILITY FOR ANY OBLIGATION WHATSOEVER. THE FACT THAT THE GOVERNMENT MAY HAVE FORMULATED THE DATA OR IN ANY WAY SUPPLIED THE SAID DRAWINGS BY CERTIFICATION OR OTHERWISE AS IN ANY MANNER LICENSING THE HOLDER OR ANY OTHER PERSON OR CORPORATION OR CONCEIVING ANY RIGHTS OF PERMISSION TO MANUFACTURE, USE, OR SELL ANY PATENTED INVENTION THAT MAY IN ANY MANNER BE DERIVED THEREFROM.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
D		19 APR 62	
E	REDRAWN AND REVISED, SEE EO SA 27441	2 NOV 64	<i>R. J. Henry</i>
F	(1) SEE EO SA 29261	18 MAY 66	<i>R. J. Henry</i>
G	(1-2) SEE EO 82048	11 MAR 68	<i>R. J. Henry</i>
H	(1) SEE EO HRD 92078-2	25 JUN 69	<i>R. J. Henry</i>
J	SEE EO HRD 02138	7 FEB 75	<i>R. J. Henry</i>
K	(3) SEE ERR HQR 40681	10 FEB 75	<i>R. J. Henry</i>
L	NOR WBS2022/79-03-26	79-04-01	<i>R. J. Henry</i>
M	NOR WBS2051/840824 ECP WBS2069 /851223	860121	<i>R. J. Henry</i>

WIRE DIAMETER ----- .054 ± .001  
 COIL DIAMETER ( O. D. ) ----- .4575 ± .0025  
 FREE LENGTH ----- 15.23 REF  
 TOTAL COILS ----- 104 REF  
 DIRECTION OF HELIX ----- R. H.  
 LOAD AT COMPRESSED LENGTH OF 10.97 ----- 8.13 LB ± .81 LB  
 LOAD AT COMPRESSED LENGTH OF 6.42 ----- 17.00 LB ± 1.69 LB  
 SPRING RATE ----- 1.95 LB/IN REF  
 SOLID LENGTH ----- 5.78 MAX  
 TYPE OF ENDS ----- CLOSED ENDS GROUND  
 MANUFACTURE IN ACCORDANCE WITH MIL-S-13572, TYPE I, GRADE B.

#### NOTES:

- HOLE DIA INTO WHICH SPRING FITS FREELY .474 MIN.
- ROD DIA OVER WHICH SPRING SLIDES FREELY .340 MAX.
- HEAT TREATMENT: AGE AT 900°F FOR 1 HOUR. AIR COOL. HEAT SET 700°F FOR 20 MINUTES WITH SPRING COMPRESSED TO 5.9 TO 6.0 INCHES.
- LOAD REQUIREMENTS SHALL APPLY AFTER SPRING HAS BEEN COMPRESSED TO SOLID LENGTH 3 TIMES.

ORIGINAL FSCM NO. 19205

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
 U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
 DOVER, NEW JERSEY 07801

(HI) (FI) (USED WITH ROD, OPERATING - 7267064)

(J)

(G2)

PART NO. 7267079

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 17 SEP 54		<del>DEPT OF THE ARMY</del> <del>ROCK ISLAND ARSENAL</del> <del>ROCK ISLAND, ILL. 61204</del>	
YP	J9386974	RIFLE, M14-NM	TOLERANCES ON DECIMALS ±	DRAFTSMAN R.S.K.	CHECKER J.P.	<b>SPRING, HELICAL, COMPRESSION</b>	
TS	F7267000	RIFLE, M14	FRACTIONS ± ANGLES ±	TRACER	CHECKER W.H.S.		
EL 2			MATERIAL: WIRE, STEEL, CORROSION RESISTANT, MIL-W-46078	ENGINEER	ENGINEER		
RA			HEAT TREATMENT SEE NOTE 3	SUBMITTED			
BH		NEXT ASSY USED ON	FINAL PROTECTIVE FINISH NONE	APPROVED		CODE-IDENT NO. 19204	DWG SIZE B
RH		DO NOT APPLY PART NO				SCALE	UNIT WT
							SHEET 1 OF 1

SWESP Form 467  
 6 MAR 63

## NOTES:

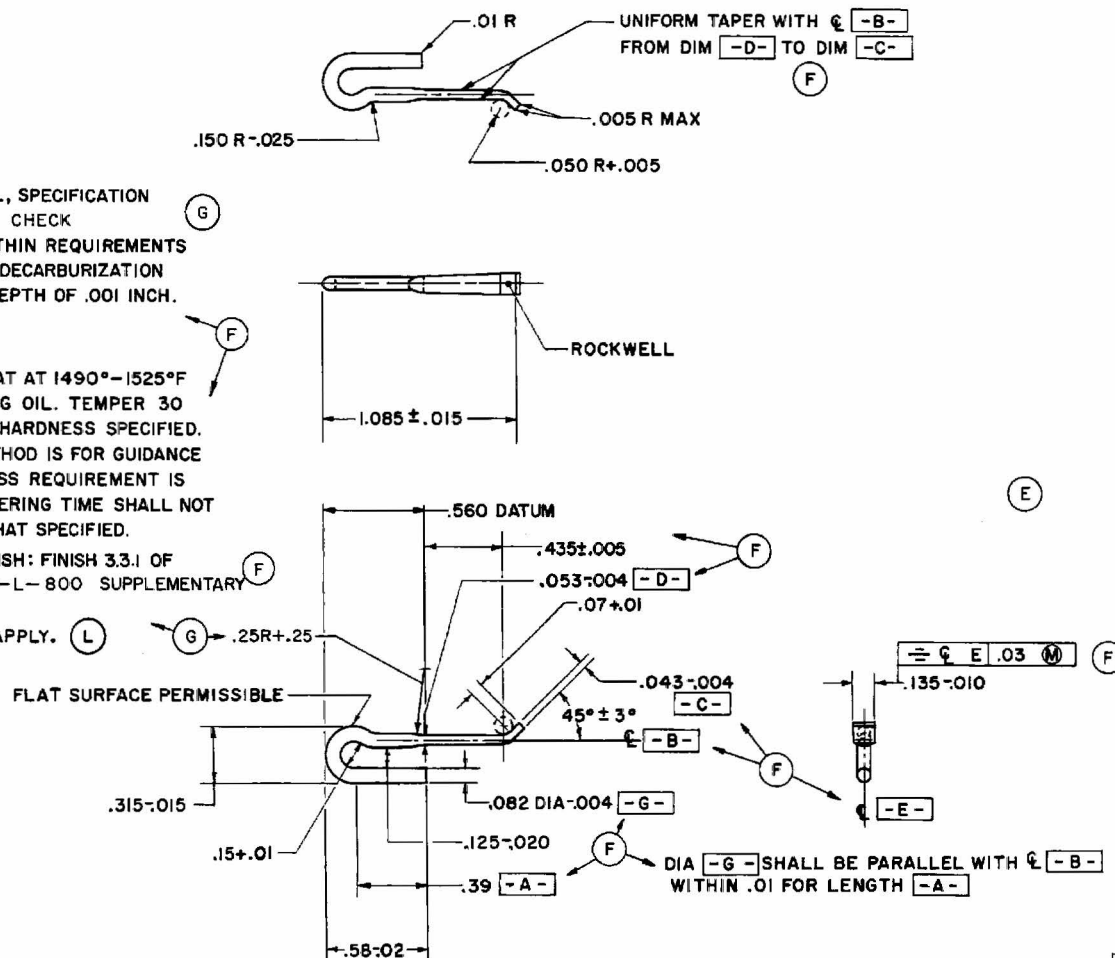
1. FINISH  $\sqrt{63}$ 

2. MATERIAL: WIRE, STEEL, SPECIFICATION  
ASTM A504, TYPE II. CHECK  
ANALYSIS SHALL BE WITHIN REQUIREMENTS  
OF TABLE I. PARTIAL DECARBURIZATION  
SHALL NOT EXCEED A DEPTH OF .001 INCH.

3. HEAT TREATMENT: HEAT AT 1490°-1525°F  
QUENCH IN CIRCULATING OIL. TEMPER 30  
MINUTES AT HEAT TO HARDNESS SPECIFIED.  
HEAT TREATMENT METHOD IS FOR GUIDANCE  
EXCEPT THAT HARDNESS REQUIREMENT IS  
MANDATORY AND TEMPERING TIME SHALL NOT  
BE REDUCED BELOW THAT SPECIFIED.

4. FINAL PROTECTIVE FINISH: FINISH 3.3.1 OF  
MIL-STD-171 WITH VV-L-800 SUPPLEMENTARY  
OIL TREATMENT.

5. MIL-W-13855 SHALL APPLY.



ORIGINAL FSCM NO. 19205

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

CODE IDENT NO. 19204  
PART NO. 7267080

PHYSICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TP		RIFLE, M14NM	TOLERANCES ON DECIMALS ±.01
TS			ANGLES FRACTIONS ±
EL 2	D7790195	RIFLE, M14	MATERIAL SEE NOTE 2
RA			HEAT TREATMENT SEE NOTE 3
BN		NEXT ASSY USED OR	FINAL PROTECTIVE FINISH SEE NOTE 4
HN	A73-77	APPLICATION	
		DO NOT APPLY PART NO.	
		AS SPECIFIED	

ORIGINAL DATE OF DRAWING 10 SEP 54  
DRAFTSMAN *[Signature]* CHECKER *[Signature]*  
TRACER *[Signature]* CHECKER *[Signature]*  
ENGINEER *[Signature]* ENGINEER *[Signature]*  
SUBMITTED *[Signature]* DRD CORPS  
APPROVED BY ORDER OF THE CHIEF OF ENGINEERING *[Signature]* DRD CORPS

SPRING, SAFETY

DEPT OF THE ARMY  
US ARMY WEAPONS  
COMMUN  
ROCK ISLAND, ILL 61201

DWG  
SIZE  
C 7267080  
SHEET 1 of 1

SCALE 2/1 UNIT WT

C 7267080

C

B

A

C 7267080

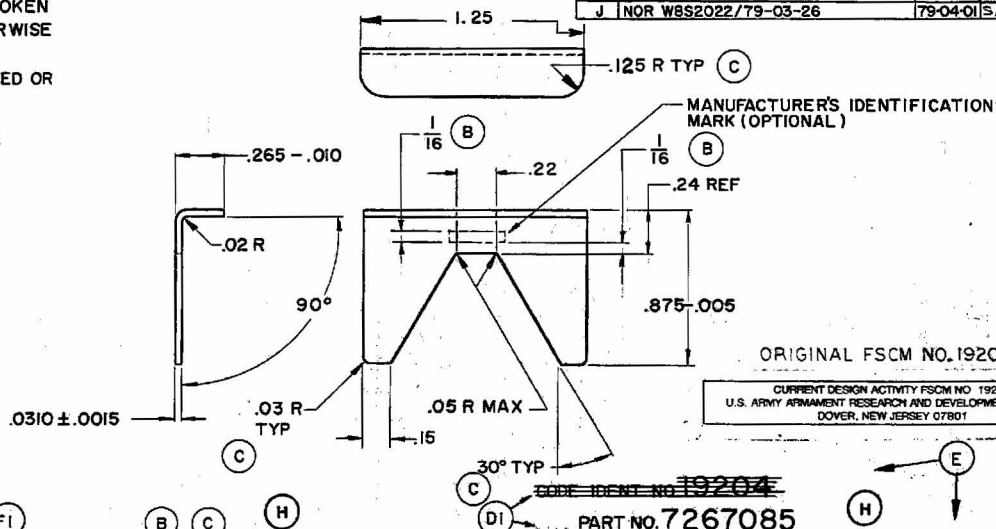
00 FORM 1176  
APR 54

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NOTES:

1. ALL EDGES SHALL BE BROKEN .002±.005 UNLESS OTHERWISE SPECIFIED.
2. FINISH 125 EXCEPT SHEARED OR STAMPED EDGES 250.
3. MIL-W-13855 SHALL APPLY.

REVIEWS		DATE	APPROVAL
SYM	DESCRIPTION		
A	REDRAWN AND REVISED SEE		
E O SA 24622		12 JUN 58	<i>R. S. Henry</i>
B	SEE EO SA 25196	1 SEP 59	<i>R. S. Henry</i>
C	SEE EO SA 26221	11 MAR 60	<i>R. S. Henry</i>
D	(1) SEE EO SA 29261	18 MAY 60	<i>R. S. Henry</i>
E	SEE EO 82048	11 MAR 60	<i>R. S. Henry</i>
F	(1) SEE EO HRD 92078-2	25 JUN 60	<i>R. S. Henry</i>
G	SEE EO HRD 02138	7 FEB 25	<i>R. S. Henry</i>
H	(3) SEE ERR HQR 40681	10 FEB 75	<i>R. S. Henry</i>
J	NOR W8S2022/79-03-26	79-04-01	<i>R. S. Henry</i>



ORIGINAL FSCM NO. 19205

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

PART NO. 7267085

PHYSICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED		ORIGINAL DATE OF DRAWING	
YP		DIMENSIONS ARE IN INCHES		18 OCT 54	
TS		TOLERANCES ON FRACTIONS DECIMALS ANGLES		DRAWN BY J. K.	CHECKED J. K.
ELZ		± 1/64 ± .01 ± 1°		TRACED C. 772	CHECKED J. K.
PA		MATERIAL: STEEL - SPEC Q-Q-S-6981 CARBON Q-Q-19, KILLED, DRAWING QUALITY.		ENGINEERED	REVIEWED
BM		HEAT TREATMENT		SUBMITTED	
RM		AT ASSEMBLY		<i>R. S. Henry</i>	ONE CORPS
DO NOT	APPLY PART NO.	FINAL PROTECTIVE FINISH		APPROVED BY ORDER OF THE	
99	—AS-SPECIFIED	AT ASSEMBLY		CHIEF OF CORPS	

STOP,  
FOLLOWER

SCALE 2/1 UNIT WT.

DEPT OF THE ARMY	
ROCK ISLAND ARSENAL	
ROCK ISLAND, ILL 61201	
QWS SEC	7267085
B	SHEET 1 OF 1

RMM

NOTE:

1 MIL-W-13855 SHALL APPLY. (P)

(R)

AFTER ASSEMBLY, LOOP SHALL  
BE CAPABLE OF BEING ROTATED  
USING LIGHT FINGER PRESSURE

LOOP-7267037

BRACKET-7267007

ORIGINAL DESIGN ACTIVITY FSCM NO.19205

U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOWER, NEW JERSEY 07001

F11010282

FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 7267089

PART NO. 7267089

MECHANICAL PROPERTIES		F11010430	MG. 7.62MM:	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 10 SEP 54		DESIGNER		CHECKER	
YP		C11686711	M60	TOLERANCES ON DECIMALS ±		DRAWN		G. V.		R. E. Aho	
TS				FRACTIONS ±		TRACER		G. V.		R. E. Aho	
EL2		F11010263	RIFLE M14	ANGLES ±		ENGINEER		G. V.		R. E. Aho	
RA				MATERIAL		SUBMITTED		G. V.		R. E. Aho	
BH				HEAT TREATMENT		APPROVED		G. V.		R. E. Aho	
RH				FINAL PROTECTIVE FINISH:		FINISH 53.12 OF MIL-STD-171		G. V.		R. E. Aho	
		APPLICATION									
		NEXT ASST		USED ON							
		APPLY PART NO.									

CURRENT DESIGN ACTIVITY FSCM NO.19200  
SWIVEL ASSEMBLY, SLING

DRG SIZE B 7267089

SCALE 2/1 UNIT WT SHEET 1 OF 1

2

**NOTE :**

MIL-W-13855 SHALL APPLY.

Ⓕ

—SEAR - 7267070

-TRIGGER - 5546020

-PIN - 5013673

UPSET CONICALLY EACH END OF THE SEAR PIN INTO THE COUNTERSINK ON THE SEAR. PIN AND SEAR ASSEMBLY SHALL MOVE FREELY ON THE TRIGGER.

C 7267090

**CURRENT DESIGN ACTIVITY FSCM NO.19200**

US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

ORIGINAL DESIGN ACTIVITY FSCM NO. 19205

~~CODE IDENT NO. 19204~~ (D)

PART NO. 7267090

FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 7267090

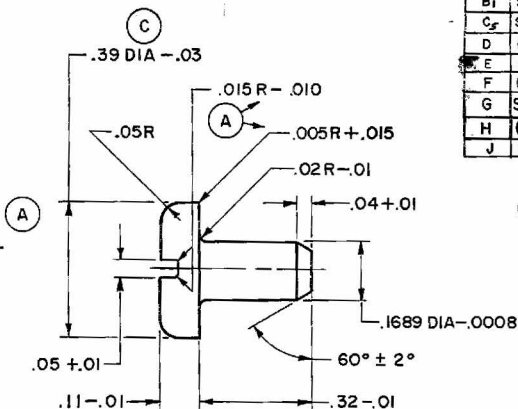
PHYSICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 10 SEP 54		REVISIONS	
TP		TOLERANCES ON ANGLES DECIMALS FRACTIONS		DRAFTSMAN A.U.A. CHECKER		DEPT OF THE ARMY	
TS		MATERIAL		TRACER CHECKER		ROCK ISLAND ARSENAL	
EL 2	D 7790195	RIFLE M 14		ENGINEER <i>[Signature]</i> ENGINEER <i>[Signature]</i>		ROCK ISLAND ARSENAL	
RA				SUBMITTED <i>[Signature]</i>		ROCK ISLAND ARSENAL	
BR		NEXT ASSY USED ON		ORD CORPS		DWG SIZE	
		HEAT TREATMENT				7267090	
RI		APPLICATION		APPROVED BY ENGINEER OR THE CHIEF OF DESIGN <i>[Signature]</i>		SCALE 2/1 UNIT WT	
		DO NOT APPLY PART NO.		FINAL PROTECTIVE FINISH		C UNIT WT	
		AS SPECIFIED					

1. FINISH  $\sqrt{125}$  ALL OVER.  
2. MATERIAL: STEEL, 4135 OR 4140,  
ASTM A322 OR A331.

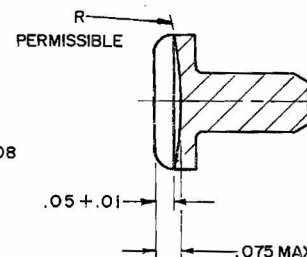
3 - HEAT TREATMENT: HEAT AT 1550° TO 1600°F. OIL QUENCH. TEMPER 20 MINUTES AT HEAT TO ROCKWELL SPECIFIED.

HEAT TREATMENT METHOD IS  
FOR GUIDANCE EXCEPT THAT TEMPER-  
ING TIME SHALL NOT BE REDUCED BE-  
LOW THAT SPECIFIED.  
NO DECARBURIZATION PERMISSIBLE.

4. MIL-W-13855 SHALL APPLY.



REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
	REDRAWN AND REVISED FORMERLY SHOWN ON DWG C73/2733 (SHEET 2)	10JUL58	R. H. Hume
A <sub>1</sub>	SEE EO SA 26615	11MAR63	R. H. Hume
B <sub>1</sub>	SEE EO SA26990	21AUG 63	R. H. Hume
C <sub>1</sub>	SEE EO SA 27608	7 SEP 65	R. H. Hume
D	(1-2) SEE EO SA29262	18MAY66	R. H. Hume
E	SEE EO 82048	11MAR 68	R. H. Hume
F	(1) SEE EO HRD 92078-2	25 JUN 69	R. H. Hume
G	SEE EO HRD 02138	71 FEB 25	R. H. Hume
H	(2) SEE ERR HQR 40681	10FEB75	R. H. Hume
J	NOR WBS2022/79-03-26	79-04-01	S. A. G. Hume



**CURRENT DESIGN ACTIVITY FSCM NO.19200**  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

DISTRIBUTION STATEMENT A. APPROVED FOR PUBLIC RELEASE; DISTRIBUTION IS UNLIMITED.

ORIGINAL FSCM NO. 19205

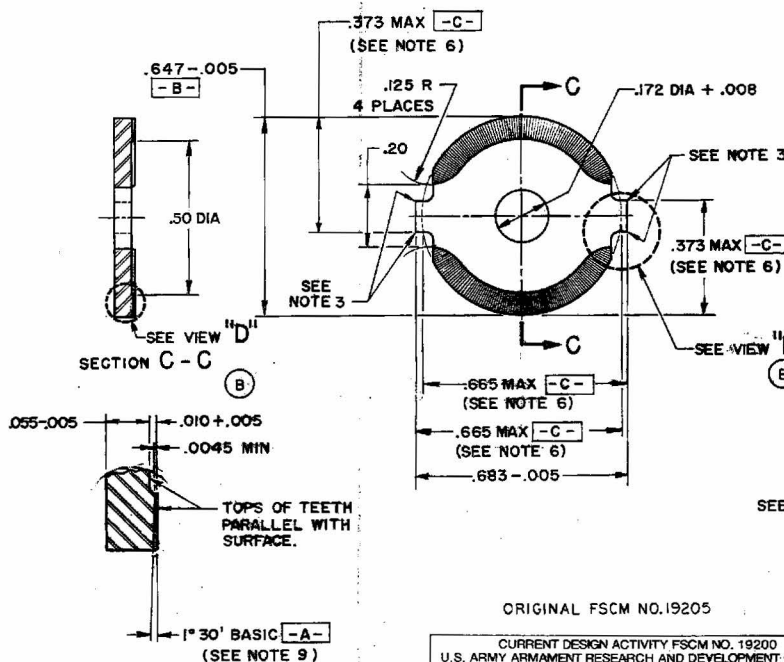
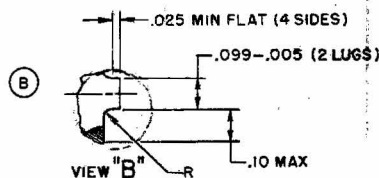
(D2) PART NO. 7267096

DISTRIBUTION STATEMENT A. APPROVED FOR PUBLIC RELEASE; DISTRIBUTION IS UNLIMITED.		ORIGINAL FSCM NO. 19205  PART NO. 7267096	
C	F1	A B C	D2
RIFLE M14NM CIIOI0362 RIFLE M14 30R-MI, MIC&MID	<b>PHYSICAL PROPERTIES</b>  VP  TS  EL2  RA  BH  RH	<b>UNLESS OTHERWISE SPECIFIED</b>  DIMENSIONS ARE IN INCHES TOLERANCES ON FRACTIONS DECIMALS ANGLES ± ± .01 ± 1°  MATERIAL  SEE NOTE 2  HEAT TREATMENT  SEE NOTE 3  FINAL PROTECTIVE FINISH AT ASSEMBLY	<b>ORIGINAL DATE OF DRAWING</b> 10 JUL 58  DRAFTSMAN CHECKER R.H.S. TRACER CHECKER R.H.S. ENGR H.H.M. ENGR S.D.S. SUBMITTED <i>R.S. Henry</i> ORG CORPS APPROVED BY ORDER OF THE CHIEF OF ORGANIZATION <i>J.F. Russell</i> ORG CORPS
NEXT ASSY USED ON APPLICATION: DO NOT APPLY PART NO. -AS SPECIFIED-		BLANK, REAR SIGHT SCREW  SPRINGFIELD ARMORY SPRINGFIELD, MA  DWG SIZE 7267096 B SHEET OF	



NOTES:

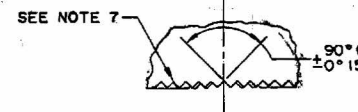
1. FINISH  $\sqrt{63}$
2. ALL CORNERS AND EDGES SHALL BE FREE FROM BURRS WITH MAX RADIUS OF .005 UNLESS OTHERWISE SPECIFIED.
3. THESE EDGES SHALL BE SHARP TO .010 R MAX AND FREE FROM BURRS.
4. RESULTANT CORNERS SHALL BE WELL DEFINED AND FREE FROM TEARS.
5. .013 MAX DEFORMATION RESULTING FROM PUNCHING AND COMING PERMISSIBLE ONE SURFACE ONLY, EITHER TOP OR BOTTOM.
6. DIMENSIONS LABELED  $-C-$  APPLY AT MAX DIA  $-B-$ .
7. 100 SERRATIONS IN 360 DEGREES. SERRATIONS SHALL BE RADIAL (CHECK FROM DIM  $-B-$ ) AND EQUIDISTANT. WHEN SERRATIONS OF ONE DOG ARE MESHED WITH SERRATIONS OF ANOTHER DOG, THE DEPTH OF ENGAGEMENT SHALL BE .004 MIN ALL AROUND THE SERRATED PORTIONS AND DIM  $-B-$  OF ONE SHALL BE CONCENTRIC WITH DIM  $-B-$  OF THE OTHER WITHIN .003.
8. HEAT TREATMENT: CARBURIZE AT 1550°-1600°F FROM .008 TO .012 DEPTH. OIL QUENCH. TEMPER ONE HOUR AT HEAT TO ROCKWELL SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED. THE USE OF STRAIGHT CYANIDE BATH OR CARBO-NITRIDING PROCESS SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF THE CONTRACTING OFFICER.
9. ANGLE  $-A-$  SHALL BE ADJUSTED AS NECESSARY TO PROVIDE CRESTS, UNIFORM IN WIDTH FOR THE LENGTH OF THE SERRATIONS.
10. MIL-W-13855 SHALL APPLY.



ORIGINAL FSCM NO.19205

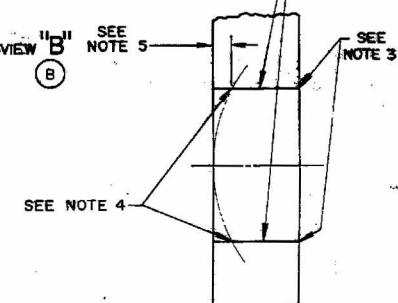
CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

REVISIONS			
LTR	DESCRIPTION	DATE	APPROVED
A	REDRAWN WITH CHANGE WAS "A" SIZE. SEE EO SR 27809	7 SEP 65	<i>S. Cole</i>
B	(1-6) SEE EO 82048	11 MAR 68	<i>S. Cole</i>
C	(1) SEE EO HRD 92078-2	25 JUN 69	<i>S. Cole</i>
D	SEE EO HRD 02138	71 FEB 25	<i>S. Cole</i>
E	NOR WSS2022/79-03-26	79-04-01	<i>S. Cole</i>
F	NORW4S2051/840824 ECPW552069 / 851223)	860121	<i>S. Cole</i>



VIEW "A" SCALE 20/1

SIDES SHALL BE SQUARE AND SMOOTH

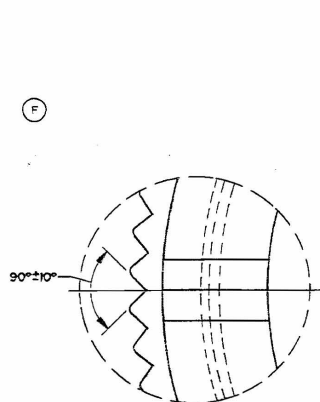


PART NO. 7267097

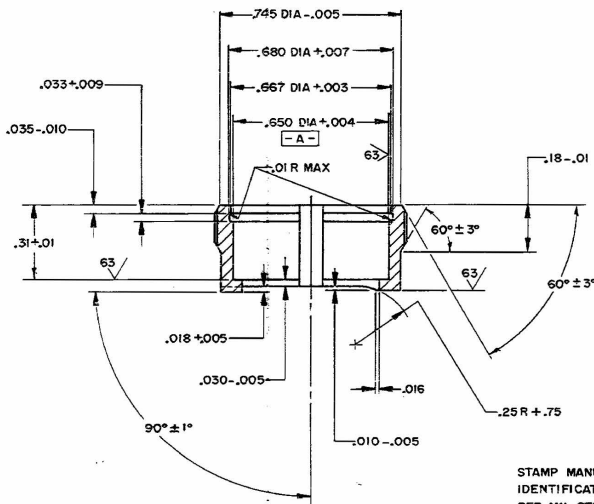
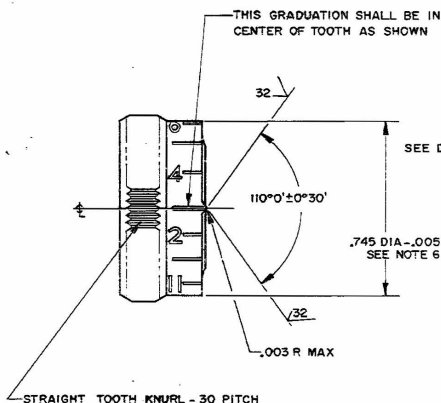
MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING		DEPT OF THE ARMY	
YP		RIFLE, MM4MM	TOLERANCES ON DECIMALS ± .01	10 JUL 58		U.S. ARMY WEAPONS COMMAND, ROSS ISLAND, ILL 61208	
TS		C11010362 RIFLE, M74	FRACTIONS ±	DRAFTSMAN	MMF	CHECKER	RHS
EL2		.30R MI.	ANGLES ±	TRACER	WHS	CHECKER	NJA
RA		MIC & MID	MATERIAL	ENGINEER	<i>S. Cole</i>	ENGINEER	<i>S. Cole</i>
BH			STEEL, FED SPEC QQ-S-698:	SUBMITTED			
RH	15N 63-72		CARBON .08 TO .18 %, KILLED				
		NEXT ASSY USED ON	HEAT TREATMENT	APPROVED			
		APPLICATION	SEE NOTE 8				
		APPLY PART NO.	FINAL PROTECTIVE FINISH	<i>R. S. Henry</i>			
			AT ASSEMBLY				
				DWG SIZE CODE IDENT NO.			
				C 19204 7267097			
				SCALE 4/1 UNIT WT SHEET 1 OF 1			

NOTES:

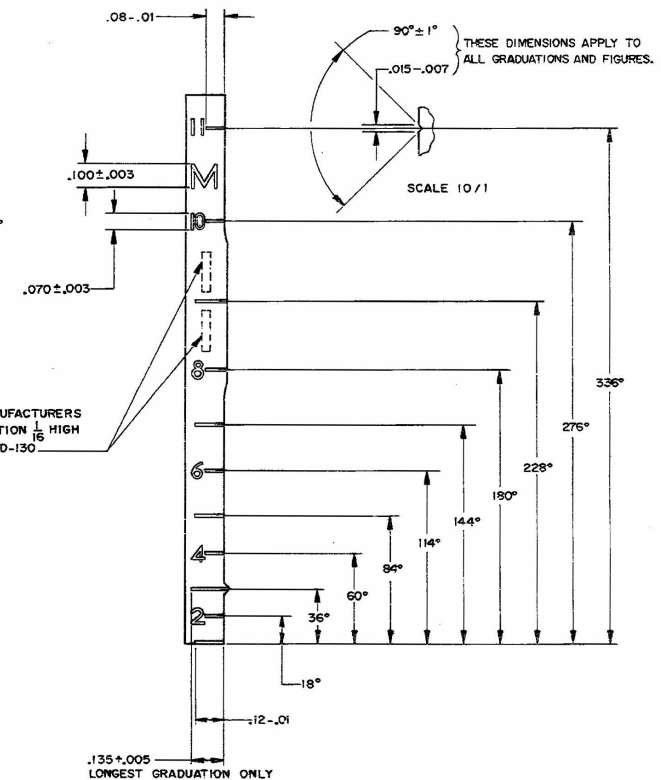
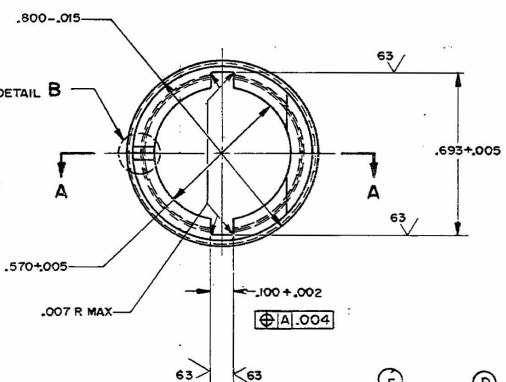
1. FINISH  $\sqrt{25}$  EXCEPT AS NOTED.
2. ALL CORNERS AND EDGES SHALL BE FREE FROM BURRS. MAX RADIUS SHALL BE .005 UNLESS OTHERWISE SPECIFIED.
3. MATERIAL: STEEL, CMPSN 1016 THRU 1020, ASTM A108, COMPII17, Q-Q-5-637, OR CMPSN 8615, SPEC ASTM A304, A322, A331, AUSTENITIC GRAIN SIZE 5 OR FINER.
4. HEAT TREATMENT: CARBURIZE AT 1575° TO 1625°F. FROM .004 TO .008 DEPTH. OIL QUENCH. TEMPER 30 MINUTES AT 350°F. CASE HARDNESS: ROCKWELL A61 TO 70 TAKEN ON PIECES USED FOR CASE DEPTH MEASUREMENT AFTER GRINDING OFF A MINIMUM OF .008 TO REMOVE ALL OF THE CASE. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT CASE DEPTH AND CORE HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED. THE USE OF STRAIGHT CYANIDE BATH OR CARBO-NITRIDING PROCESSES SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF THE CONTRACTING OFFICER.
5. GRADUATION LINE THROUGH THE INDEXING TOOTH (DETENT) MAY FADE OUT FOR THE LAST .015 NEAREST THE APEX OF THE TOOTH. (SEE ZONE B6)
6. THIS DIAMETER SHALL APPLY BETWEEN GRADUATIONS. DIAMETER OVER GRADUATIONS SHALL BE .748 MAX. (SEE ZONE B5)
7. MIL-W-12855 SHALL APPLY.
8. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.



DETAIL B  
SCALE 20/1



SECTION A-A



DEVELOPED VIEW

ORIGINAL FSCM NO. 19205

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

PART NO. 7267098

DEPT OF THE ARMY  
ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201

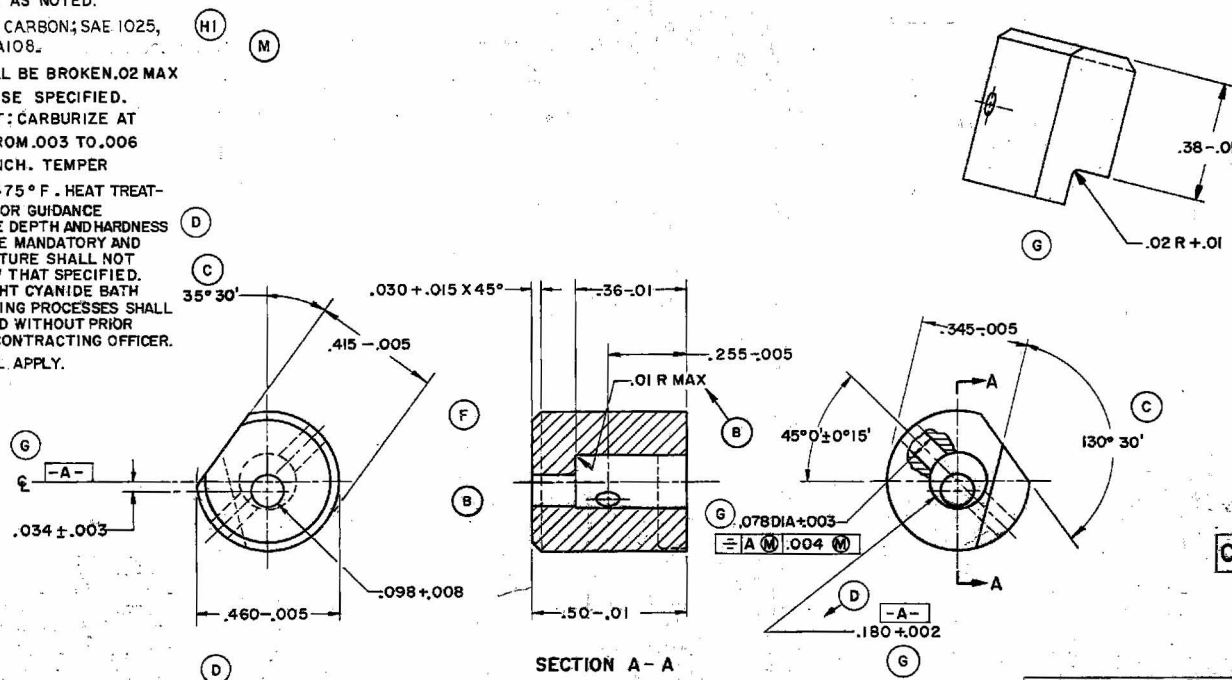
KNOB, REAR SIGHT ELEVATING

ENG SIZE CODE IDENT NO. 7267098  
D 19204  
SCALE 4/1 UNIT WT .01 SHEET 1 OF 1

MECHANICAL PROPERTIES	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	ORIGINAL DATE OF DRAWING
TP	TOLERANCES ON DECIMALS ± .010	10 JUL 58
TS	FRACTIONS ± .010	
EL2	ANGLES ± 0° 30'	
RA		
BH	RIFLE M14 NM	
RH	RIFLE M14	
SEE NOTE 487	SEE NOTE 3	
	HEAT TREATMENT	
	SEE NOTE 4	
	FINAL PROTECTIVE FINISH	
	SEE NOTE 8	

NOTES:

1. FINISH 125 EXCEPT AS NOTED.
2. MATERIAL: STEEL, CARBON; SAE 1025, 1117, 1118; ASTM A108.
3. ALL EDGES SHALL BE BROKEN .02 MAX UNLESS OTHERWISE SPECIFIED.
4. HEAT TREATMENT: CARBURIZE AT 1575°-1600°F FROM .003 TO .006 DEPTH. OIL QUENCH. TEMPER 30 MINUTES AT 375°F. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED. THE USE OF STRAIGHT CYANIDE BATH OR CARBO-NITRIDING PROCESSES SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF THE CONTRACTING OFFICER.
5. MIL-W-13855 SHALL APPLY.



SECTION A-A

ORIGINAL FSCM NO. 19205

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

CODE IDENT NO. 19204  
PART NO. 7267172

PHYSICAL PROPERTIES		TOLERANCES ON DIMENSIONS ARE, IN INCHES	
TP	F 7267000	ANGLES ± 1°	DECIMALS
EL 2	F 7791363	FRACTIONS	
MA		MATERIAL SEE NOTE 2	
WH		HEAT TREATMENT SEE NOTE 4	
HH		APPLICATION	
HH		DO NOT APPLY PART NO. 40-570-570	
SEE NOTES		FINAL PROTECTIVE FINISH FINISH NO. 5, 3, 1, 2 OR 5, 3, 2, 2 OF MIL-STD-171	
FILE HARD			

ORIGINAL DATE OF DRAWING	25 OCT 54
DRAFTSMAN C.W.M.	CHECKER
ENGINEER	CHECKER
SUBMITTED	
APPROVED BY	ORD CORPS
ORD CORPS	

LOCK,  
SELECTOR  
SHAFT

DEPT OF THE ARMY	7267172
ROCK ISLAND ARSENAL	
ROCK ISLAND, ILLINOIS 62201	
SCALE 4/1	UNIT WT
SHEET 1	OF 1

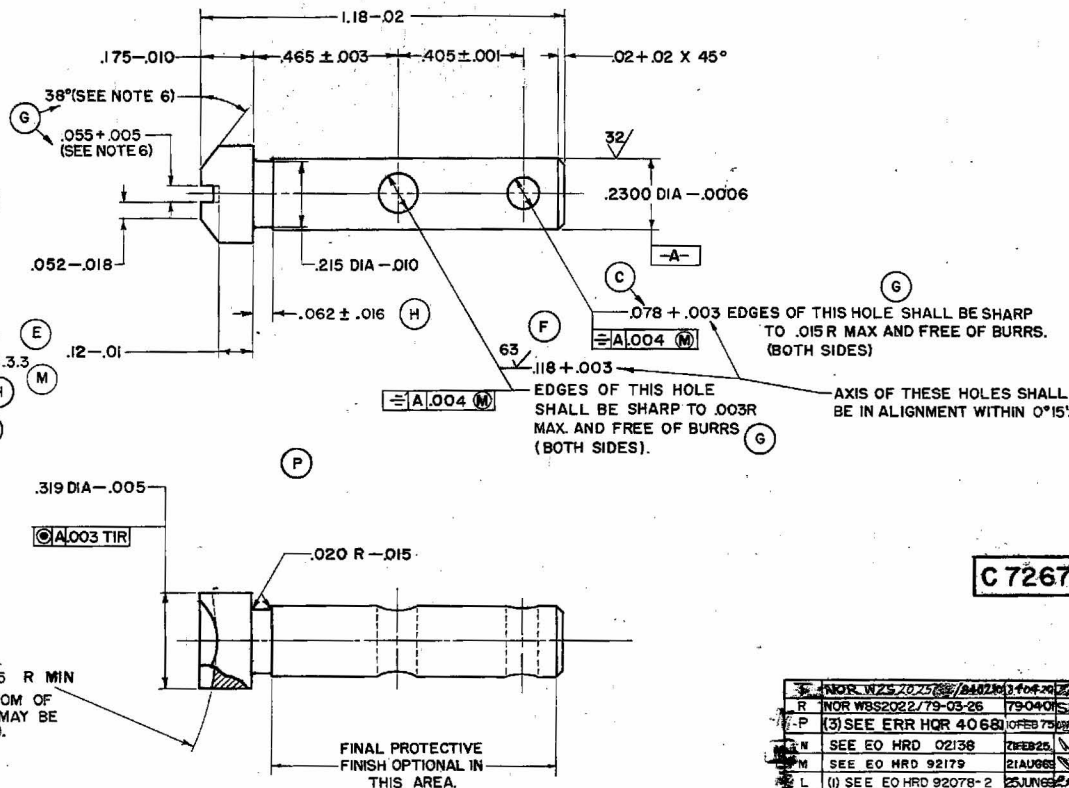
P	ECPW552069 / 851223	860121	
N	NC 1 W852022 / 79-03-26	790401	SA 100
M	(2) SEE ERR HQR 40681	10 FEB 75	ENG
L	SEE EO HRD Q2138	11 FEB 75	J. A. Cole
K	(1) SEE EO HRD 92078-2	25 JUN 75	B. F. F.
J	(1-2) SEE EO 82048	11 MAR 76	B. F. F.
H	(1-2) SEE EO SA 29262	18 MAY 76	B. F. F.
G	SEE EO SA 25892	28 JUN 76	B. F. F.
F	SEE EO SA 26794	3 JAN 77	B. F. F.
E	SEE EO SA 26404	1 MAR 77	B. F. F.
D	SEE EO SA 25974	23 DEC 77	B. F. F.
C	SEE EO SA 25233	12 SEP 78	B. F. F.
B	SEE EO SA 24785	12 SEP 78	B. F. F.
A	REDRAWN AND REVISED	10 JUL 78	B. F. F.
	SEE EO SA 24529		
SYN	DESCRIPTION	DATE	APPROVAL

C7267172

C7267172

NOTES:

- 1-FINISH 125/ EXCEPT AS NOTED.
- 2-ALL EDGES SHALL BE BROKEN .005+.010 UNLESS OTHERWISE SPECIFIED.
- 3-MATERIAL: CORROSION RESISTING STEEL, SPEC QQ-S-763 CLASS 440A, CONDITION A
- 4-HEAT TREATMENT: HEAT TO 1850°-1900° F. OIL QUENCH. TEMPER 30 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
- 5-FINAL PROTECTIVE FINISH: FINISH NO. 3.3.2 OR 3.3.3 OF MIL-STD-171 WITH SUPPLEMENTARY PRESERVATIVE CONFORMING TO VV-L-800.
- 6-38° SURFACES AND .055 SLOT SHALL BE IN ALIGNMENT WITH .118±.003 HOLE WITHIN 5°.
- 7-MIL-W-13855 SHALL APPLY.



U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

ORIGINAL DESIGN ACTIVITY FSCM NO. 19205

FSCM NO.  
19200

PART NO. 7267604

PHYSICAL PROPERTIES	APPLICATION	DO NOT	APPLY PART NO.
TP			
SLZ	F7267000		
RA			
BH			
PH	C 48-52		

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON DECIMALS	
ANGLES $\pm 1^{\circ}$	FRACTIONS:
MATERIAL	
SEE NOTE 3	
HEAT TREATMENT	
SEE NOTE 4	
FINAL PROTECTIVE FINISH	
SEE NOTE 5	

APPROVED BY	DATE
R. S. Henry	28 DEC 1954
W. S. Lynch	

VALVE,  
GAS CUTOFF

DEPT OF THE ARMY	UNIT WT
ROCK ISLAND ARSENAL	
7267604	
C	

CC7267604

C 7267604

REVISIONS	DATE	APPROVE
1. NOR WZS 20 25 75/0402M 3104-20		
2. NOR WBS2022/79-05-26	79-04-01	
3. SEE ERR HQR 40680	10 FEB 79	
4. SEE EO HRD 02138	20 FEB 25	
5. SEE EO HRD 92179	21 AUG 68	
6. (1) SEE EO HRD 92078-2	23 JUN 68	
7. SEE EO 82048	11 MAR 68	
8. (1-2) SEE EO SA 29261	30 MAR 68	
9. SEE EO SA 27537	9 JAN 68	
10. SEE EO SA 26750	21 JAN 68	
11. SEE EO SA 26781	15 OCT 67	
12. SEE EO SA 25975	23 OCT 60	
13. SEE EO SA 24970	15 DEC 58	
14. SEE EO SA 24811	25 OCT 58	
15. REDRAWN AND REVISED	10 JUL 58	
16. SEE EO SA 24529	14 SEP 55	

NOTES: WHEN GOVERNMENT DRAWINGS, SPECIFICATIONS OR OTHER DATA ARE USED FOR ANY PURPOSE OTHER THAN IN CONNECTION WITH A DEFINITELY RELATED GOVERNMENT PROCUREMENT OPERATION, THE UNITED STATES GOVERNMENT THEREBY INCURS NO RESPONSIBILITY FOR ANY OMISSION, ERROR, OR INADEQUACY. THE GOVERNMENT MAY HAVE FORMULATED OR IN ANY WAY SUPPLIED THE SAID DRAWINGS, SPECIFICATIONS OR OTHER DATA IS NOT TO BE CONSIDERED BY THE USER OR OTHERS AS IN ANY MANNER ENDORSED OR RECOMMENDED BY THE GOVERNMENT. NO PART OF THIS DOCUMENT IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM THE GOVERNMENT. RIGHTS IN ANY PATENT OR OTHER INTELLECTUAL PROPERTY THAT MAY BE IN ANY WAY AFFECTED THEREBY.

ASSEMBLED HEIGHT (BASIC) ----- 272  
 WIRE DIAMETER (APPROX) ----- .040  
 OUTSIDE DIA SOLID, NOT MORE THAN ----- .323  
 INSIDE DIA FREE, NOT LESS THAN ----- .233  
 FREE LENGTH ----- .345 REF  
 TOTAL COILS ----- 5 REF  
 DIRECTION OF HELIX ----- OPTIONAL  
 LOAD AT COMPRESSED LENGTH OF .272 ----- 4 LB MIN  
 LOAD AT COMPRESSED LENGTH OF ----- LB± LB  
 SPRING RATE ----- 50 LB/IN REF  
 SOLID LENGTH ----- .208 MAX  
 TYPE OF ENDS ----- CLOSED ENDS  
 ----- GROUND

MANUFACTURE IN ACCORDANCE WITH  
 MIL-S-13572, TYPE I, GRADE B.

# NOTES:

- HOLE DIA INTO WHICH SPRING FITS FREELY .328 MIN.
- ROD DIA OVER WHICH SPRING SLIDES FREELY .230 MAX.
- MATERIAL: WIRE, STEEL, CORROSION-RESISTING, SPEC QQ-W-423: 302 OR 304 CONDITION B. (K)
- HEAT TREATMENT: STRESS RELIEVE FOR ONE HOUR AT 700 °F AFTER COILING.
- LOAD REQUIREMENT SHALL APPLY AFTER SPRING HAS BEEN COMPRESSED TO SOLID LENGTH 3 TIMES.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
D		8 NOV 63	
E	REDRAWN & REVISED SEE EO SA 27441	2 NOV 64	<i>[Signature]</i>
F	(1) SEE EO SA 29261	18 MAY 66	<i>[Signature]</i>
G	SEE EO RIA-13912	1-20-67	<i>[Signature]</i>
H	(1) SEE EO HRD 92078-2	25 JUN 69	<i>[Signature]</i>
J	SEE EO HRD 02138	21 FEB 75	<i>[Signature]</i>
K	(2) SEE ERR HQ 40681	10 FEB 75	<i>[Signature]</i>
L	NOR WBS2022/79-03-26	79-04-01	<i>[Signature]</i>
M	NOR WBS2025 84-02-10	84-04-20	<i>[Signature]</i>

(F1) (K) (M) (J)  
 (USED WITH VALVE - 7267604)

ORIGINAL DESIGN ACTIVITY FSCM NO. 19205

CURRENT DESIGN ACTIVITY FSCM NO. 19200

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE 28 DEC 54		U.S. ARMY AMMUNITION RESEARCH AND DEVELOPMENT CENTER DUPONT NEW JERSEY 07071	
YP		TOLERANCES ON DECIMALS ±		DRAFTSMAN C.W.M.	CHECKER E.E.K.	SPRING, HELICAL, COMPRESSION	
TS	F7267600	FRACTIONS ± ANGLES ±		TRACER T.M.S.	CHECKER W.H.S.		
EL 2	RIFLE, M14	MATERIAL SEE NOTE 3		ENGINEER [Signature]	ENGINEER [Signature]		
RA	NEXT ASSY USED ON	HEAT TREATMENT SEE NOTE 4		SUBMITTED [Signature]			
BH	APPLICATION	FINAL PROTECTIVE FINISH NONE		APPROVED [Signature]		CODE/IDENT NO. 19204 DWG SIZE B SCALE UNIT WT SHEET 1 OF 1	
RH	DO NOT APPLY PART NO					7267605	
	AS SPECIFIED						

- NOTES:  
 1. SPECIFICATION MIL-B-1309 APPLIES.  
 2. TO COVER BRIGHT SURFACES WHICH ARE EXPOSED DURING ASSEMBLING OPERATIONS, TOUCH-UP PROCEDURE SHALL BE IN ACCORDANCE WITH MIL-W-13855.

GRIP - 7267653

GRIP - 7267652

PIN - MS 16562 -125

LEVER - 7267648

2 - SCREW - 11010078

SECTION A-A  
 SCALE  $\frac{2}{1}$

SECTION B-B  
 SCALE  $\frac{2}{1}$

OPENING OF SPRING PIN  
 WITHIN 15° OF HORIZONTAL

SIDE VIEW WITH RH GRIP REMOVED

SPRING - 7267645

BLADE ASSEMBLY - 7267649

APPLY MODEL NUMBER AS SHOWN  
 (12 HIGH AND .010 MINIMUM DEPTH)  
 BEFORE APPLICATION OF PROTECTIVE FINISH.

D7267616

FOR LIST OF PARTS,  
 SEE ENGINEERING PARTS LIST 7267616

PHYSICAL PROPERTIES TOLERANCES ON DECIMALS MATERIAL HEAT TREATMENT APPLICATION DO NOT APPLY PART NO. 40-SPRINGS-		ORIGINAL DATE 24 JAN 55 OF DRAWING TRACER ENGINEER SUBMITTED APPROVED 40-SPRINGS-		REVISIONS 1. SEE ERR MOR 20692 2. SEE EO HAD 92106 3. SEE EO SA 25490 4. REDRAWN AND REVISED 5. SEE EO SA 25490	
B8427015 BAY-KN: M6 W/SCABBARD USED ON		ORIGINAL DATE 24 JAN 55 OF DRAWING TRACER ENGINEER SUBMITTED APPROVED 40-SPRINGS-		REVISIONS 1. SEE ERR MOR 20692 2. SEE EO HAD 92106 3. SEE EO SA 25490 4. REDRAWN AND REVISED 5. SEE EO SA 25490	
BAY-KN: M6 W/SCABBARD USED ON		ORIGINAL DATE 24 JAN 55 OF DRAWING TRACER ENGINEER SUBMITTED APPROVED 40-SPRINGS-		REVISIONS 1. SEE ERR MOR 20692 2. SEE EO HAD 92106 3. SEE EO SA 25490 4. REDRAWN AND REVISED 5. SEE EO SA 25490	
BAY-KN: M6 W/SCABBARD USED ON		ORIGINAL DATE 24 JAN 55 OF DRAWING TRACER ENGINEER SUBMITTED APPROVED 40-SPRINGS-		REVISIONS 1. SEE ERR MOR 20692 2. SEE EO HAD 92106 3. SEE EO SA 25490 4. REDRAWN AND REVISED 5. SEE EO SA 25490	

BAYONET-KNIFE, M6		DEPT OF THE ARMY ROCK ISLAND ARSENAL ROCK ISLAND ILL. 61201	
7267616		7267616	

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
D		29 SEP 60	
E	REDRAWN & REVISED SEE EO SA 27456	15 MAY 64	
F	SEE HQP - 31608	1 FEB 73	

NOTICE - WHEN GOVERNMENT DRAWINGS SPECIFICATIONS ARE USED IN ANY MANUFACTURING OPERATION, THE UNITED STATES GOVERNMENT ASSUMES NO LIABILITY FOR ANY INADEQUACIES OR DEFICIENCIES IN THE DRAWING OR SPECIFICATIONS. THE USER OF THIS DRAWING SHALL BE RESPONSIBLE FOR THE DESIGN AND CONSTRUCTION OF THE MANUFACTURED PARTS AND FOR THE PROTECTION OF THE UNITED STATES GOVERNMENT AGAINST ANY INADEQUACIES OR DEFICIENCIES IN THE DRAWING OR SPECIFICATIONS. THE USER SHALL BE RESPONSIBLE FOR THE DESIGN AND CONSTRUCTION OF THE MANUFACTURED PARTS AND FOR THE PROTECTION OF THE UNITED STATES GOVERNMENT AGAINST ANY INADEQUACIES OR DEFICIENCIES IN THE DRAWING OR SPECIFICATIONS.

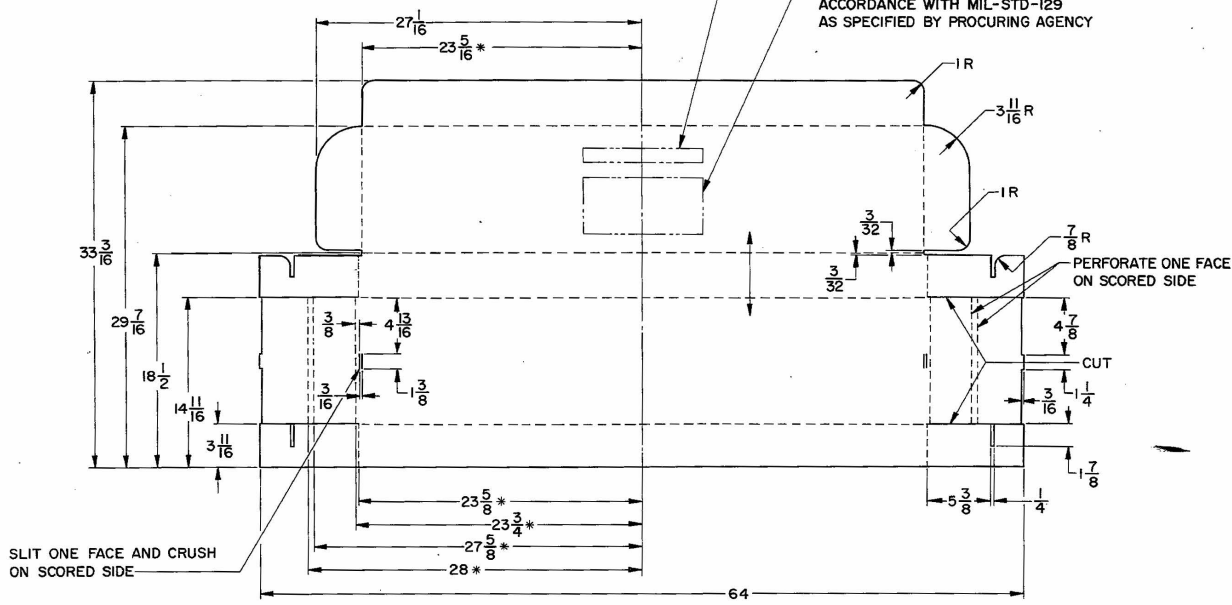
- NOTES:
1. MATERIAL: DOUBLE FACED CORRUGATED FIBERBOARD  
COMPLIANCE SYMBOL ----- V3c  
FLUTE ----- B  
SPECIFICATION ----- PPP-B-636
  2. ----- SCORE THIS SIDE
  3. ----- DIRECTION OF CORRUGATION
  4. \* TOLERANCE BETWEEN SCORED LINES  $\pm \frac{1}{16}$

PRINTING REQUIRED ON SIDE OPPOSITE SCORED SIDE WITH INK CONFORMING TO SPEC TT-I-559, COLOR BLACK.

PRINT THE FOLLOWING IN THIS SPACE

REUSABLE BOX  
3/8

PRINT IN THIS SPACE APPLICABLE UNIT PACKAGE MARKINGS IN ACCORDANCE WITH MIL-STD-129 AS SPECIFIED BY PROCURING AGENCY



MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 8 MAR 55		PART NO 7267724	
YP		TOLERANCES ON DECIMALS $\pm$		DRAFTSMAN	CHECKER	DEPT OF THE ARMY	
TS		FRACTIONS $\pm 1/16$ ANGLES $\pm$		TRACER	CHECKER	ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
EL 2	D8449427	MATERIAL		ENGINEER	ENGINEER	BOX, DIECUT	
RA	SEE ENGINEERING RECORDS	SEE NOTE 1		SUBMITTED		CODE IDENT NO DWG SIZE	
BH	NEXT ASSY USED ON	HEAT TREATMENT		APPROVED		00000 D	7267724
RH	APPLICATION	FINAL PROTECTIVE FINISH		SCALE 1/5		UNIT WT	SHEET 1 OF 1
DO NOT APPLY PART NO						PDC	

NO ONE WHEN GOVERNMENT DRAWINGS SPECIFICALLY  
OR OTHERWISE ARE USED FOR ANY PURPOSE OTHER THAN  
IN CONNECTION WITH A DEFINITELY RELATED GOVERNMENT  
PROJECT. THE UNITED STATES GOVERNMENT  
THEREBY MAKES NO REPRESENTATION OR WARRANTY  
WHATEVER AND THE FACT THAT THE GOVERN-  
MENT MAY HAVE FORMULATED, UNISHED OR IN ANY WAY  
SUPPLIED THE SAID DRAWING OR SPECIFICATION OR OTHER  
DATA IS NOT TO BE INTERPRETED BY ANY INDIVIDUAL OR  
OTHER PERSON OR CORPORATION, OR INDIVIDUAL OR  
RIGHTS OF INVENTION TO MANUFACTURE, OR TO SELL  
AND PATENTED INVENTION THAT MAY IN ANY WAY BE  
DERIVED THEREFROM.

WIRE DIAMETER ----- .0350  $\pm$  .0005  
COIL DIAMETER ( O. D. ) ----- .148  $\pm$  .002  
FREE LENGTH ----- 2.13 REF  
TOTAL COILS ----- 40 REF  
DIRECTION OF HELIX ----- R H  
LOAD AT COMPRESSED LENGTH OF 1.56 ----- 21.5 LB  $\pm$  1 LB  
LOAD AT COMPRESSED LENGTH OF 1.45 ----- 25.7 LB  $\pm$  1 LB  
SPRING RATE ----- 38.33 LB/IN REF  
SOLID LENGTH ----- 1.44 MAX  
TYPE OF ENDS ----- OPEN ENDS GROUND  
MANUFACTURE IN ACCORDANCE WITH MIL-S-13572, TYPE I, GRADE A.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
C		22 OCT 63	
D	REDRAWN & REVISED SEE EO SA 27441	2 NOV 64	<i>[Signature]</i>
E	(1) SEE EO SA 29262	18 MAY 66	<i>[Signature]</i>
F	(1-2) SEE EO 82046	11 MAR 68	<i>[Signature]</i>
G	(1) SEE EO HRD 92078-2	25 JUN 69	<i>[Signature]</i>
H	SEE EO HRD 02138	21 FEB 70	<i>[Signature]</i>
J	(3) SEE ERR HQ 40681	10 FEB 75	<i>[Signature]</i>
K	NOR WBS2022/79-03-26	79-04-01 SA 1721	
L	NORW4S2051/840824 ECPW5S2069 / 851223	860121	<i>[Signature]</i>

# NOTES:

- FIRST COIL ON BOTH ENDS SHALL BE FORMED TO .069 + .004 INSIDE DIAMETER.
- HOLE DIA INTO WHICH SPRING FITS FREELY .152 MIN.
- ROD DIA OVER WHICH SPRING SLIDES FREELY MAX.
- HEAT TREATMENT: STRESS RELIEVE AT 425 °F. TO 445 °F. FOR 30 MIN, AFTER COILING.
- LOAD REQUIREMENTS SHALL APPLY AFTER SPRING HAS BEEN COMPRESSED TO SOLID LENGTH 3 TIMES.

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

(USED WITH EJECTOR - 72670M4)

(E1) ORIGINAL FSCM NO. 19205

PART NO. 7267959

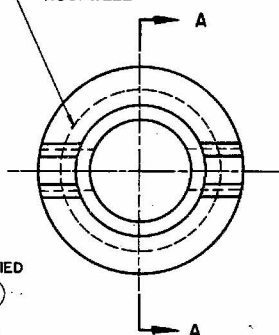
MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 1 SEP 55		SPRINGFILE SPRINGFILE	
YP		TOLERANCES ON DECIMALS $\pm$		DRAFTSMAN C.L.B.	CHECKER E.F.K.	<b>SPRING, HELICAL, COMPRESSION</b>	
TS	RIFLE, M14	FRACTIONS $\pm$ ANGLES $\pm$		TRACER T.M.S.	CHECKER W.H.S.		
EL 2	B72670M5 RIFLE, M14	MATERIAL: STEEL, WIRE. SPEC QQ-W-470		ENGINEER <i>[Signature]</i>	ENGINEER <i>[Signature]</i>		
RA	NEXT ASSY USED ON APPLICATION	HEAT TREATMENT SEE NOTE 4		SUBMITTED <i>[Signature]</i>	APPROVED <i>[Signature]</i>		
BH		DO NOT APPLY PART NO		FINAL PROTECTIVE FINISH LUB OIL, SPEC VV-L-800		CODE IDENT NO. DWG SIZE <b>7267959</b>	
RH		AS SPECIFIED		SCALE UNIT WT SHEET OF		19204 B 7267959	



NOTES:

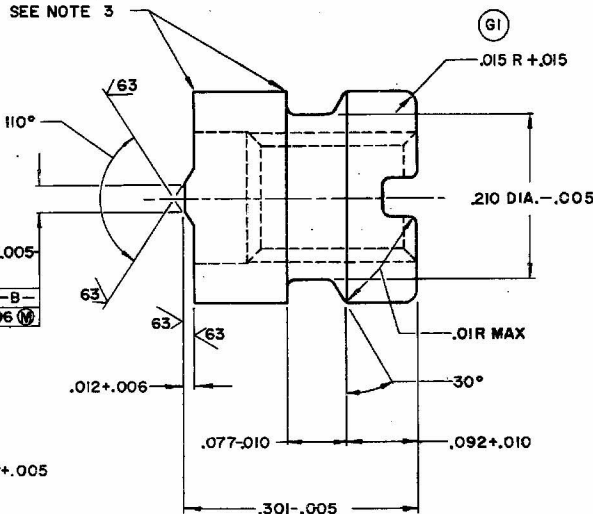
1. FINISH 125/ EXCEPT AS NOTED.
2. BREAK EDGES AND CORNERS .005R MAX UNLESS OTHERWISE SPECIFIED. ALL CORNERS AND EDGES SHALL BE FREE OF BURRS.
3. THESE CORNERS ARE IMPORTANT FUNCTIONING POINTS.
4. RADIAL POSITIONING OF  $\text{---C---}$  RELATIVE TO  $\text{---B---}$  IS OPTIONAL.
5. HEAT TREATMENT: HEAT TO 1525 °-1550 °F OIL QUENCH. TEMPER TO HARDNESS SPECIFIED NO DECARBURIZATION PERMISSIBLE. HEAT TREATMENT IS FOR GUIDANCE ONLY EXCEPT THAT HARDNESS AND DECARBURIZATION REQUIREMENTS ARE MANDATORY.
6. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OF MIL-STD-171.
7. MIL-W-13855 SHALL APPLY.

ROCKWELL



SEE NOTE 3

$\text{---B---}$   
 $\text{---A---}$  .006 TIR



$\text{---G1---}$   
.015 R+.015

.210 DIA.+.005

.01R MAX

30°

.012+.006

.077-.010

.092+.010

.301-.005

.220-.015

.045+.010

.015R-.010

.050+.006

$\text{---C---}$

.164 (N.O.8) - 36 UNF-3B

$\text{---A---}$  .006 TIR

.01R MAX

SEE NOTE 3

.265 DIA.+.003

$\text{---A---}$

SECTION A-A

PHYSICAL PROPERTIES	APPLICATION	FINAL PROTECTIVE FINISH:
D7790386	DO NOT	SEE NOTE 6
D7312737	APPLY PART NO.	
RIFLE M4NM		
RIFLE M4		
30RM.MC.MD		
MATERIAL: STEEL, CARBON,		
GRADE 1141, ASTM A108		
HEAT TREATMENT		
SEE NOTE 5		

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES  
TOLERANCES ON DECIMALS  
ANGLES ±1°  
MATERIAL: STEEL, CARBON,  
GRADE 1141, ASTM A108  
HEAT TREATMENT  
SEE NOTE 5  
FINAL PROTECTIVE FINISH:  
SEE NOTE 6

PART NO. 7312726

ORIGINAL DATE OF DRAWING 9 DEC 1944  
CHECKED BY V.W.G. CHECKER  
DRAWN BY J.A.C. CHECKER  
SUBMITTED BY R. L. Henry  
APPROVED BY H. J. Lynch  
SCALE 10/1 UNIT WT R.M.H.

NUT, REAR SIGHT

DEPT OF THE ARMY

ROCK ISLAND ARSENAL

ROCK ISLAND ARSENAL

7312726

C7312726  
CURRENT DESIGN ACTIVITY FSCM NO.19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801  
ORIGINAL DESIGN ACTIVITY FSCM NO.19205

N	DESCRIPTION	DATE	APPROVAL
NORW4S2046/840717		850521	MR
M	NOR WBS2022/79-03-26	79-04-05	AM
L	(1) SEE ERR HQR 40681	10FEB75	AM
K	SEE EO HRD 02138	71FEB25	AM
J	(2) SEE EO HRD 92078-2	25JUN63	AM
H	(1-4) SEE EO-62023	20FEB68	AM
G	(1-2) SEE EO SA 29261	18MAY66	AM
F	REF EO NO. SA 28627	8 FEB63	AM
E	REF EO NO. SA 24900	4 DEC 58	AM
D	REDRAWN AND REVISED	04JUN58	AM
C	SEE EO SA 24523	17SEP57	AM

DUPLICATE ORIGINAL

DRAWING SIZE C 4

3

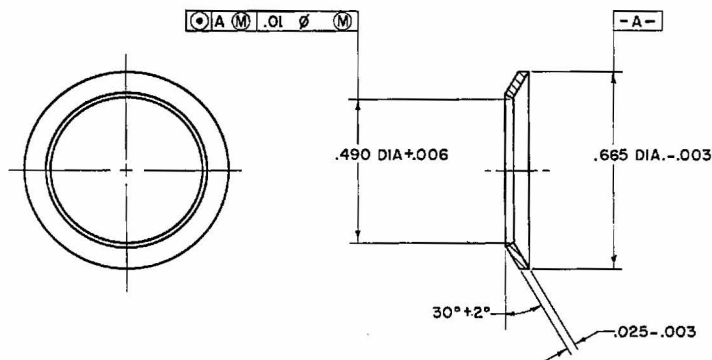
2

1

## NOTES:

1. FINISH  $63\sqrt{\text{ALL OVER.}}$
2. ALL EDGES SHALL BE BROKEN .005 MAX AND SHALL BE FREE FROM BURRS.
3. OUTSIDE DIA TO BE CYLINDRICAL, WITHIN DIM.  $\boxed{-A-}$  LIMITS, AS WOULD RESULT FROM SHEARING AFTER RETAINER IS MADE CONICAL.
4. MATERIAL: STEEL, SPEC. QQ-S-698: CARBON .17 MIN. CR QUARTER HARD NO. 3 TEMPER, OR SPEC. ASTM A109: TEMPER NO. 3 (QUARTER HARD)
5. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
N	REDRAWN WITH CHANGE ERR 2921172AY IECP W6S0095/860915	890915	<i>5/15</i> OKP - CH



CURRENT DESIGN ACTIVITY CAGE CODE 19200  
U.S. ARMY  
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER  
PICATINNY ARSENAL, NEW JERSEY 07806-5000

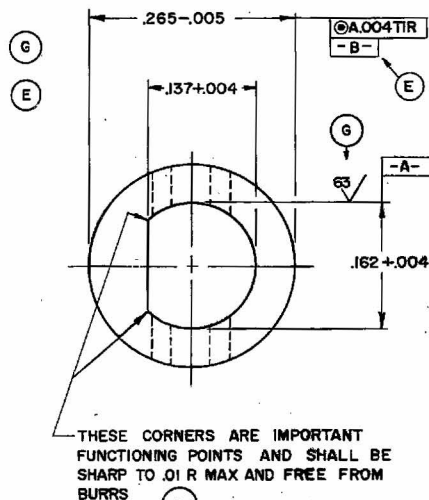
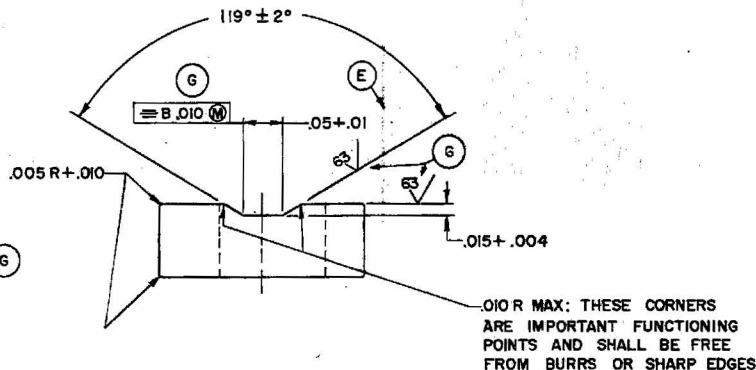
PART NO. 7312727

		MECHANICAL PROPERTIES		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING DECEMBER 09, 1944		SPRINGFIELD ARMORY, SPRINGFIELD, MASS.	
		YP		TOLERANCES ON DECIMALS *		DRAFTSMAN	CHECKER	RETAINER, DOG	
		TS		FRACTIONS * ANGLES *		AHG	EFK		
D11010363	RIFLE, M14NM	EL2		THIRD ANGLE PROJECTION		ENGR	ENGR		
A11010364	30R-M1, MIC	RA				DH	AC		
	B, MID	BH				ENGR	ENGR		
NEXT ASSY	USED ON	RH				SUBMITTED R. S. HENRY		SIZE CODE ENT NO.	
APPLICATION						APPROVED H. F. LYNCH		C 19205 7312727	
								SCALE 4/1 UNIT WT. SHEET 1 OF 1	

SMCAR FORM 67, 1 MAR 87(TEMP). REPLACES SMCAR FORM 67, 1 JUN 86(TEMP),  
WHICH MAY BE USED UNTIL EXHAUSTED

# NOTES

1. FINISH  $\sqrt{25}$  EXCEPT AS NOTED.
2. ALL CORNERS AND EDGES SHALL BE FREE FROM BURRS WITH MAX RADIUS TO BE .005 UNLESS OTHERWISE SPECIFIED.
3. MATERIAL: STEEL, CARBON, STRIP, ASTM A109
4. HEAT TREATMENT: CARBURIZE AT 1550°-1600°F FROM .004 TO .008 DEPTH. OIL QUENCH. TEMPER 20 MINUTES AT 350°F APPROX. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED. THE USE OF STRAIGHT CYANIDE BATH OR CARBO-NITRIDING PROCESS SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF THE CONTRACTING OFFICER.
5. MIL-W-13855 SHALL APPLY.



ORIGINAL DESIGN ACTIVITY FSCM NO. 19205

C7312731

P	NOR W4S2051/840824 (REF W6S2069/851223)	860121	J. Ann
N	NOR W4S2046/840717	850521	MR. Ann
M	NOR W6S2022/79-03-26	790401	SA/R. Ann
L	SEE EO MRD 02138	71FEB28	N.A.C.
K	(1) SEE EO MRD 92078-2	25JUN83	
J	(1-3) SEE EO-82023	20FEB88	
H	(1) SEE EO SA 29261	30NOV88	
G	REF EO NO. SA 26326	30NOV88	
F	REF EO NO. SA 24900	4DEC88	
E	SEE EO. SA 24873	22OCT88	
D	REDRAWN W/O CHANGE	10JUN89	
C		17SEP87	
OTH	DESCRIPTION	REVISIONS	DATE

U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

CODE IDENT NO. 19204  
PART NO. 7312731

PHYSICAL PROPERTIES	79396974	RIFLE M4-M
VP	07790386	NM-30R-MI
TS		RIFLE M14
EL2	07312737	30R-MIMIC MD
MR		
NR		
APPLICATION	DO NOT	APPLY PART NO.
FILECARD		

TOLERANCES ON DIMENSIONS	DECIMALS
FRACTIONS	
MATERIAL	SEE NOTE 3
HEAT TREATMENT	SEE NOTE 4
FINAL PROTECTIVE FINISH	FINISH NO. 5.5.1.2 OF MIL-STD-171

ORIGINAL DATE OF DRAWING	9 DEC 44
DRAWN BY	J. L. J.
CHECKED BY	OK
TRACED BY	J. C. G.
CHECKED BY	OK
ENGINEER	R. J. Henry
SUBMITTED	
APPROVED BY	
CHIEF OF DRAWING	

LOCK, REAR  
SIGHT NUT

FSCM NO. 19200

SCALE: 10/1

UNIT WT

DEPT. OF THE ARMY  
US ARMY WEAPONS  
ENGINEERING  
ROCKISLAND, ILL. 61201

7312731

C

DUPLICATE ORIGINAL

**FREE POSITION**

← .0165-0020

⑥

.105-.025 -A-  
SEE NOTE 4

**MUST BE A  
TRUE RADIUS**

**C7312732**

### COMPRESSED POSITION

$\frac{32}{\sqrt{\quad}} = .377 + .005$

ROCKWELL 1  
(LOCATION OPTIONAL)

—[38 MAX AT ANY PART OF THE CIRCLE

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

P	NOR G2S3011/92-02-04	92 03 03	65
N	ECPCWS2068 / 7851223	660121	64
	NORWAS2051/ 840824		
M	NOR WBS2022/ 79-01-26	79 04 01	SAIC 12
L	SEE ERR NOR 40081	10 FEB 79	
K	SEE EO HRD 02138	27 FEB 79	1158
J	(1) SEE EO HRD 92078-2	25 JUN 79	1158
H	SEE EO 85048	11 MAR 66	
G	(1) SEE EO SA 29281	10 MAY 68	
F	SEE EO SA 27608	7 SEP 65	
E	SEE EO SA 27301	7 AUG 64	
D3	SEE EO SA 26890	2 AUG 63	1158
C	REORDAIN AND REVISED SEE EO S245029	0 JUL 58	1158
B		DEC54	
BY	DESCRIPTION	DATE	APPROVAL

PART NO. 7312732

PHYSICAL PROPERTIES		RIFLE M4/M1A RIFLE, M4		TOLERANCES ON DECIMALS ANGLES FRACTIONS	
TY	D11010363	30R-M16 MIC		MATERIAL STEEL ASTM A494, 1095 SPHEROIDIZED ANNEAL	
TS	A11010364	8 MID		HEAT TREATMENT SEE NOTE 5	
CLAS					
SA					
SH		HEAT TREAT	USED ON		
		APPLICATION			
NO	SUPPLEMENTAL EN 83-85	DO NOT	APPLY PART NO.	FINAL PROTECTIVE FINISH SEE NOTE 6	

ORIGINAL DATE OF DRAWING		9 DEC 44	
DRAFTSMAN	F.R.C.	CHECKER	JK
TRACER	H.S.	CHECKER	JK
ENGINEER	H. Horn	ENGINEER	J. S. K.
SUBMITTED			
R. S. Henry			
APPROVED			
C. S. K.			

SPRING , REAR  
SIGHT  
CAGE CODE 19205

**CAGE CODE 19205**

**SPRINGFIELD**  
**ARMORY**  
**SPRINGFIELD, MA**

DRUG STATE	7312732
---------------	---------

40

RMH

- I. FINISH <sup>125</sup>✓ EXCEPT AS NOTED.

2. ALL CORNERS AND EDGES SHALL BE FREE FROM BURRS. MAX RADIUS SHALL BE .005 UNLESS OTHERWISE SPECIFIED.

3. MATERIAL: STEEL, FED SPEC QQ-S-634:1016 THRU 1020, SPEC QQ-S-637:1117 OR SPEC ASTM A322, A331:8615. AUSTENITIC GRAIN SIZE 5 OR FINER AS DETERMINED BY FED TEST METHOD STD NO. 151, METHOD 311, PROCEDURE A.

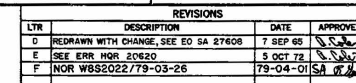
4. HEAT TREATMENT: CARBURIZE AT 1575° TO 1625°F. FROM .004 TO .008 DEPTH. OIL QUENCH. TEMPER 30 MINUTES AT 350°F. CASE HARDNESS: FILE HARD. CORE HARDNESS: ROCKWELL A61 TO 70 TAKEN ON PIECES USED FOR CASE DEPTH MEASUREMENT AFTER GRINDING OFF A MINIMUM OF .008 TO REMOVE ALL OF THE CASE. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT CASE DEPTH AND CORE HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED. THE USE OF STRAIGHT CYANIDE BATH OR CARBO-NITRIDING PROCESSES SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF THE CONTRACTING OFFICER.

5. GRADUATION LINE THROUGH THE INDEXING TOOTH (DETENT) MAY FADE OUT FOR THE LAST .015 NEAREST THE APEX OF THE TOOTH. (SEE ZONE B6)

6. THIS DIAMETER SHALL APPLY BETWEEN GRADUATIONS. DIAMETER OVER GRADUATIONS SHALL BE .748 MAX. (SEE ZONE B5)

7. FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171,  
EXCEPT PARA 3.3 OF MIL-P-16232 SHALL NOT  
APPLY. (E)

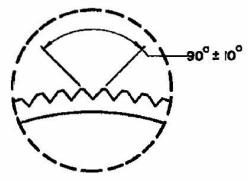
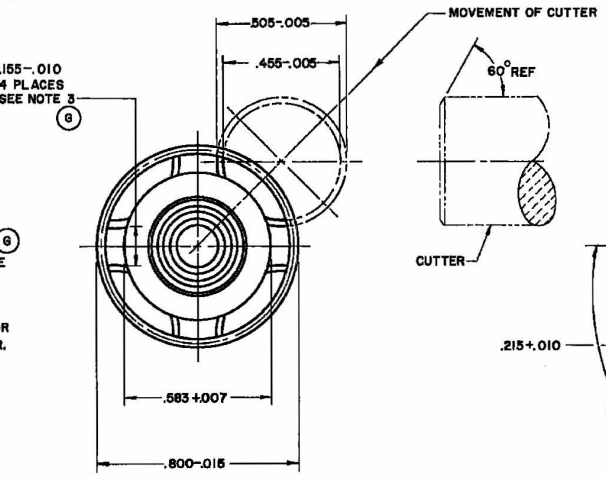
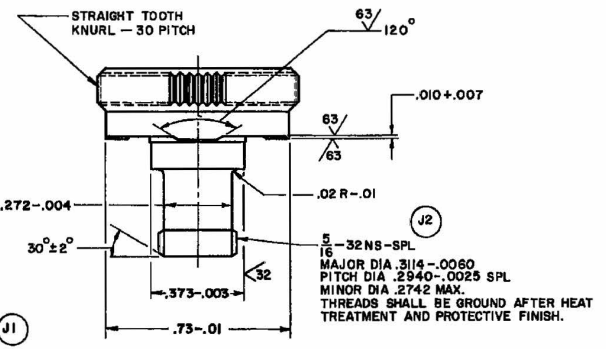
8. MIL - W-13855 APPLIES.



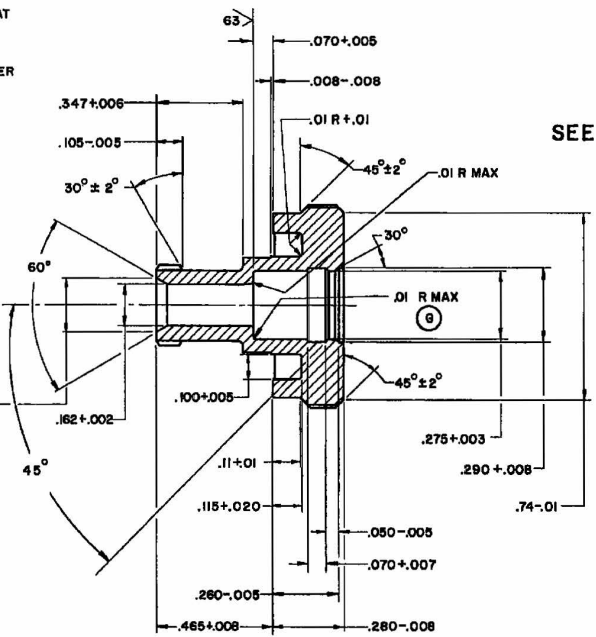
MECHANICAL PROPERTIES				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 9 DEC 44		PART NO. 1 STEP 1	
YP				TOLERANCES ON DECIMALS = .010		DRAWNMAN <i>WHS</i> CHECKER <i>DSK</i>		CHECKED BY: <i>WHS</i> APPROVED BY: <i>WHS</i> DATE: <i>12/10/44</i>	
TS				FRACTIONS = 1/16 ANGLES = 0°/30'		TRACER <i>WHS</i> CHECKER <i>DSK</i>			
EL 2	A11010364	.30R M1, MRC		MATERIAL		ENGINEER <i>WHS</i> ENGINEER <i>DSK</i>			
RA		S MID		SEE NOTE 3		SUBMITTED			
BH		NEXT ASSY		HEAT TREATMENT		<i>D. D. Cole</i>		KNOB, REAR SIGHT ELEVATING	
RH	SEE NOTE 4	USED ON		SEE NOTE 4		APPROVER <i>R. Henry</i>			
		APPLICATION		FINAL PROTECTIVE FINISH		DWG. SET		DWG. CODE	
				SEE NOTE 7		1944		7312734	
						D		SCALE 4/1 UNIT WT. OI	
								SHEET 1 OF 1	

NOTES: WHEN GOVERNMENT DRAWINGS, SPECIFICATIONS, OR OTHER DATA ARE USED FOR ANY PURPOSE OTHER THAN IN CONNECTION WITH A SPECIFICALLY RELATED GOVERNMENT PROCUREMENT, THE UNITED STATES GOVERNMENT HEREBY DISCLAIMS ANY LIABILITY FOR ANY DEFECTS, ERRORS, OR OMISSIONS IN ANY SUCH DATA. THE GOVERNMENT MAY HAVE FORMULATED, FURNISHED, OR IN ANY MANNER SUPPLIED THE DATA ORIGINALLY AND ANY DEFECTS, ERRORS, OR OMISSIONS IN ANY SUCH DATA ARE NOT TO BE DEEMED TO BE THE RESPONSIBILITY OF THE UNITED STATES GOVERNMENT. THE UNITED STATES GOVERNMENT WILL NOT BE RESPONSIBLE FOR ANY DEFECTS, ERRORS, OR OMISSIONS IN ANY SUCH DATA. THE UNITED STATES GOVERNMENT WILL NOT BE RESPONSIBLE FOR ANY DEFECTS, ERRORS, OR OMISSIONS IN ANY SUCH DATA. THE UNITED STATES GOVERNMENT WILL NOT BE RESPONSIBLE FOR ANY DEFECTS, ERRORS, OR OMISSIONS IN ANY SUCH DATA.

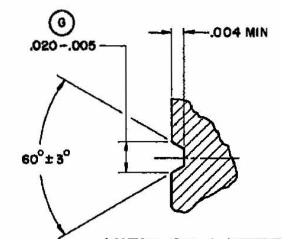
- NOTES:
1. FINISH 125 EXCEPT AS NOTED.
  2. ALL EDGES AND CORNERS SHALL BE BROKEN .005 R MAX. AND FREE OF BURRS, UNLESS OTHERWISE SPECIFIED.
  3. IT IS PERMISSIBLE TO HAVE THIS DIMENSION .165-.025 ON ANY TWO OF THE WIDTHS.
  4. MATERIAL: STEEL, CARBON, GRADE 1022 1117, ASTM A108, AUSTENITIC GRAIN SIZE 5 OR FINE. FED TEST METHOD STD NO 151, METHOD 311.1 PROCEDURE A.
  5. HEAT TREATMENT: CARBURIZE AT 1550° TO 1600° F. FROM .008 TO .010 DEPTH. OIL QUENCH. TEMPER 20 MIN AT 350° F. (SEE NOTE 8)
  6. HARDNESS: FILE HARD OR SUPERFICIAL ROCKWELL 15 N 90 MINIMUM.
  7. CASE DEPTH SHALL BE MEASURED ON TEST PIECES HEAT TREATED AT THE SAME TIME AND SHALL BE MEASURED BY THE DEPTH OF THE FRACTURED CASE. CORE HARDNESS SHALL BE ROCKWELL A61-73 TAKEN ON THE TEST PIECES USED FOR CASE DEPTH MEASUREMENT AFTER GRINDING OFF A MINIMUM OF .010 TO REMOVE ALL OF THE CASE.
  8. HEAT TREATMENT METHOD (SEE NOTE 5) IS FOR GUIDANCE EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED. THE USE OF STRAIGHT CYANIDE BATH OR CARBO-NITRIDING PROCESS SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF THE CONTRACTING OFFICER.
  9. MIL-W-13855 APPLIES.



DETAIL B  
SCALE 10/1

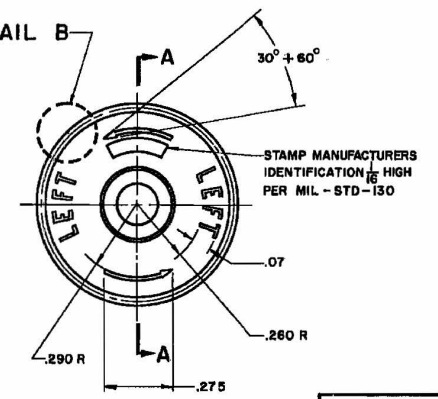


SECTION A-A



VIEW OF LETTERS  
AND ARROWS  
SCALE 50/1

SEE DETAIL B



D7312735

ORIGINAL DESIGN ACTIVITY FSCM NO. 19205  
CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

PART NO. 7312735

PHYSICAL PROPERTY	APPLICATION	HEAT TREATMENT	FINAL PROTECTIVE FINISH
1. D7312737	RIFLE, M14	SEE NOTE 4	SEE NOTE 4
2. 508M14CAND			
3. 508M14CAND			
4. 508M14CAND			
5. 508M14CAND			
6. 508M14CAND			
7. 508M14CAND			
8. 508M14CAND			
9. 508M14CAND			
10. 508M14CAND			

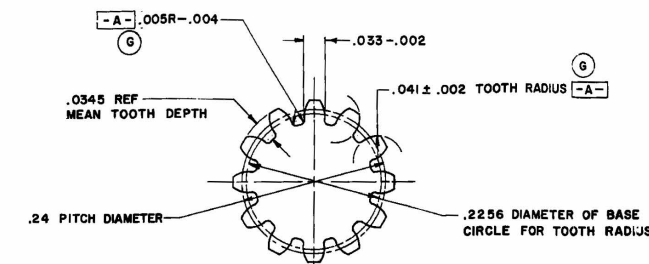
ORIGINAL DATE OF DRAWING 9 DEC 44  
DRAWN BY S. L. (CHECKED BY S. L.)  
DESIGNED BY S. L. (CHECKED BY S. L.)  
ENGINEERED BY S. L. (CHECKED BY S. L.)  
SUBMITTED BY S. L. (CHECKED BY S. L.)  
APPROVED BY S. L. (CHECKED BY S. L.)  
DATE 9 DEC 44

REVISIONS	DATE	APPROVAL
1. 9 DEC 44		
2. 9 DEC 44		
3. 9 DEC 44		
4. 9 DEC 44		
5. 9 DEC 44		
6. 9 DEC 44		
7. 9 DEC 44		
8. 9 DEC 44		
9. 9 DEC 44		
10. 9 DEC 44		

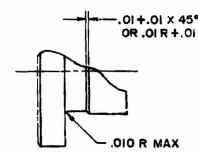
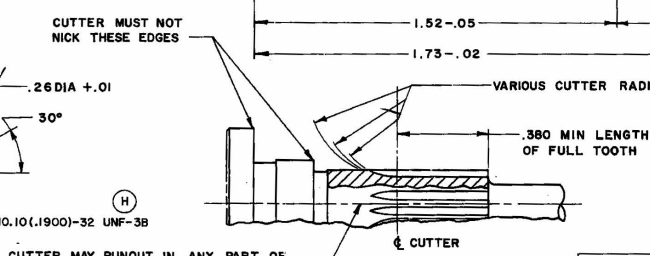
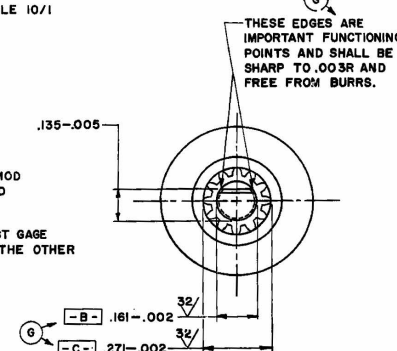
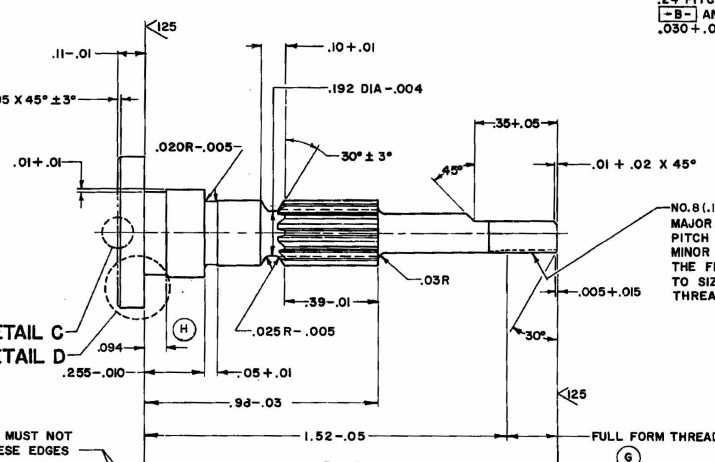
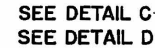
DEPT OF THE ARMY  
ROOM 10 AND ARSENAL  
ROOM 10 AND ARSENAL  
ROOM 10 AND ARSENAL  
ROOM 10 AND ARSENAL  
ROOM 10 AND ARSENAL  
ROOM 10 AND ARSENAL  
ROOM 10 AND ARSENAL  
ROOM 10 AND ARSENAL  
ROOM 10 AND ARSENAL

SCALE 4/1 UNIT WT .05

1. FINISH  $\frac{63}{\sqrt{2}}$  EXCEPT AS NOTED.
2. ALL CORNERS AND EDGES SHALL BE FREE FROM BURRS WITH MAX RADIUS OF .005 UNLESS OTHERWISE SPECIFIED.
3. 100 SERRATIONS MUST BE RADIAL (CHECK FROM DIMENSION  $-D-$ ) AND EQUIDISTANT. WHEN SERRATIONS OF ONE PINION ARE MESHED WITH SERRATIONS OF ANOTHER, THE DEPTH OF ENGAGEMENT SHALL BE  $\frac{1}{16}$  IN MIN ALL AROUND THE SERRATED SURFACES, AND DIMENSION  $-D-$  OF ONE PINION SHALL BE CONCENTRIC WITH SAME DIMENSION ON THE OTHER PINION WITHIN .003.
4. DIAMETERS  $-C-$   $-E-$  AND  $-B-$  SHALL BE GROUND AFTER HEAT TREATMENT AND PROTECTIVE FINISH.
5. HEAT TREATMENT: HEAT AT 1525°F TO 1550°F, OIL QUENCH, TEMPER 30 MINUTES AT 800°F. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
6. FINAL PROTECTIVE FINISH: FINISH 53.12 OR 53.2 OF MIL-STD-171.
7. MIL-W-38855 SHALL APPLY.



12 TEETH - 50 PITCH - .0628 CP - STANDARD MODIFIED **-A-**  
NUTTALL 20° PRESSURE ANGLE STUB TOOTH. NOTE:  
.24 PITCH DIA TO BE CONCENTRIC WITH BEARING SURFACES  
**-B-** AND **-C-** WITHIN .003 WITH RESULTANT TOOTH DEPTH OF  
.030 + .009



**DETAIL D**



	(H)		(K)		(G)
PHYSICAL PROPERTIES		RIFLE M16/M1A			
17	DII010363	RIFLE M14		TOLERANCE ON WEIGHT ± 0.1	
18	A1I7010364	30R-M1M16		WEIGHT 1.1	
19		M16		SPEC QQ-S-837-I	
20				1187, (M)	
21		NEXT ASST	USED ON	HEAT TREATMENT	
22				SEE NOTE 5	
23	C 35-40	APPLICATION			
24	DO NOT	APPLY PART NO.		FINAL ROTATIVE FINISH	
25	DO	OR OTHERWISE		NOTE 6	

PART NO. <b>7312736</b>		SIZE	DESCRIPTION	DATE	APPROVAL
ORIGINAL DATE OF DRAWING <b>5 DEC 44</b>		REVISIONS			
APPROVED FOR CONSTRUCTION	DESIGNED BY	DRAWN BY			
TRACER <b>54</b>	CHECKED <b>54</b>	BY <b>SPRINGFIELD ARMY</b>			
SUBMITTED	EXAMINED	BY <b>SPRINGFIELD MA</b>			
<b>R.S. Henry</b> ORG CORP.		BY <b>7312736</b>			
APPROVED FOR CONSTRUCTION	DESIGNED BY	DRAWN BY			
<b>4/5/44</b>	<b>4/5/44</b>	BY <b>7312736</b>			
SCALE	4 1/1 UNIT WT. .03	BY <b>7312736</b>			

PINION,  
ELEVATING,  
REAR SIGHT  
CAGE CODE 19205

REVISIONS	
1	SPRINGFIELD ARMORY SPRINGFIELD, MA
DWG FILE	7312736



1178

6 5 4 3 2 1

NOTES:

1. LOCATION OF MANUFACTURER'S IDENTIFICATION MARK FOR THIS ASSEMBLY SHOWN ON KNOB 7312735.

2. WHEN ASSEMBLED TO RIFLE, THIS ASSEMBLY SHALL READILY ENGAGE THE PINION BY USE OF A SCREWDRIVER AND THE FINGERS ONLY. THE KNOB SHALL ENGAGE AND OPERATE THE REAR SIGHT BASE THROUGH THE FULL RANGE OF THE NINE GRADUATIONS FOR WINDAGE STAMPED UPON THE REAR OF THE RECEIVER.

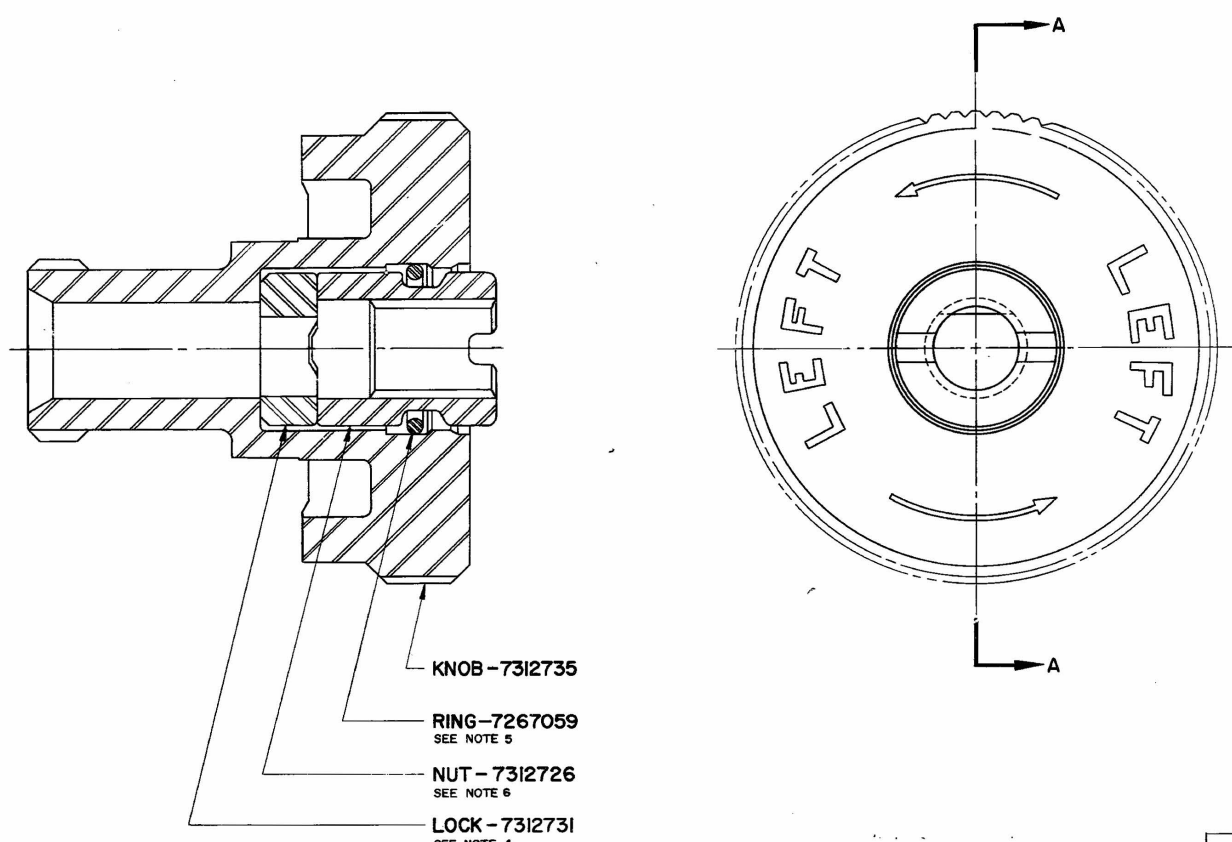
3. WHEN ASSEMBLED TO THE RIFLE, IT SHALL BE POSSIBLE TO TIGHTEN THE NUT ON THE PINION WITH A SCREWDRIVER, SUFFICIENTLY, SO THAT BOTH KNOBS BECOME INOPERATIVE BY USE OF THE FINGERS ONLY. BY BACKING OFF THE NUT ONE OR TWO CLICKS (ONE HALF TURN PER CLICK) BOTH KNOBS SHALL THEN BE OPERATIVE BY USE OF THE FINGERS.

4. NOTCH IN THE LOCK 7312731 SHALL ENGAGE THE TOOTH ON THE NUT 7312726.

5. INSERT RING INTO RECESS OF NUT AND PRESS NUT FIRMLY INTO HOLE OF KNOB USING CIRCULAR MOTION.

6. THE NUT SHALL HAVE FREE MOVEMENT ROTATIONALLY AND ENDWISE TO PERMIT READY DISENGAGEMENT FROM THE NOTCH IN THE LOCK, BUT IT SHALL NOT DISASSEMBLE FROM THE KNOB EXCEPT BY FORCIBLE MEANS.

7. MIL-W-13855 APPLIES.



KNOB - 7312735

RING - 7267059  
SEE NOTE 5

NUT - 7312726  
SEE NOTE 6

LOCK - 7312731  
SEE NOTE 4

SECTION A-A

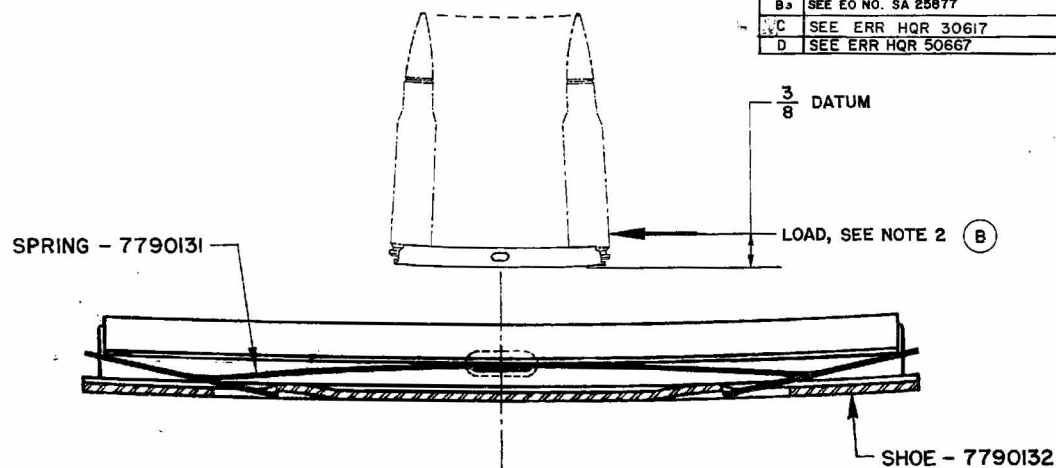
ORIGINAL DESIGN ACTIVITY FSCM NO. 19205		M NOR WBS2046/840717		850521 MR	
CURRENT DESIGN ACTIVITY FSCM NO. 19200		G NOR WBS2022/79-0826		730401 JLT	
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER		F (USE EO - 82023)		807001 JLT	
DOVER, NEW JERSEY 07801		E SEE EO SA29281		807001 JLT	
		D SEE EO SA26417		807001 JLT	
		C REDRAWN W/O CHANGE		807001 JLT	
		B		807001 JLT	
		A		807001 JLT	

SEE SEPARATE PARTS LIST 7312737		PART NO. 7312737	
PHYSICAL PROPERTIES		ORIGINAL DATE OF DRAWING 9 DEC 44	
TP	F7265698 3OR - M I	DIFFERENCE R.C. CHECKER S.22	
TS	F7265699 3OR - M I C	TRACES A.F.S. CHECKER S.22	
ELI	F7265700 3OR - M I D	ENGINEER S.22	
EN	F7267000 RIFLE, M I 4	SUBMITTED	
SH		R. S. Henry	
SH		APPROVED BY THE CHIEF OF BUREAU	
TOLERANCES ON DECIMALS		SCALE 10/1 UNIT WT	
TOLERANCES ON FRACTIONS		RMH	
MATERIAL		DUPLICATE ORIGINAL	
HEAT TREATMENT			
FINAL PROTECTIVE FINISH			

KNOB, WINDAGE, REAR SIGHT, ASSEMBLY		DEPT OF THE ARMY	
		ROCK ISLAND ARSENAL	
		ROCK ISLAND, ILL 61201	
		D 7312737	
		SHEET 1 OF 1	

87790130

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
A1	REF EO NO. SA 24560	19 JAN 58	<i>R. H. H. H.</i>
B3	SEE EO NO. SA 25877	13 NOV 61	<i>R. H. H. H.</i>
C	SEE ERR HQR 30617	22 JAN 73	<i>R. H. H. H.</i>
D	SEE ERR HQR 50667	25 JUN 73	<i>R. H. H. H.</i>



# NOTES

1. THE SUPPLEMENTARY FINISH (MIL-W-3688) OF ALL COMPONENTS SHALL BE COMPLETELY DRY FOR A MINIMUM OF 20 MINUTES PRIOR TO ASSEMBLY.

(B) 2. THE LOAD REQUIRED TO STRIP ONE END CARTRIDGE FROM A FULLY LOADED CLIP SHALL NOT BE LESS THAN 1.8 POUNDS OR GREATER THAN 4.7 POUNDS.

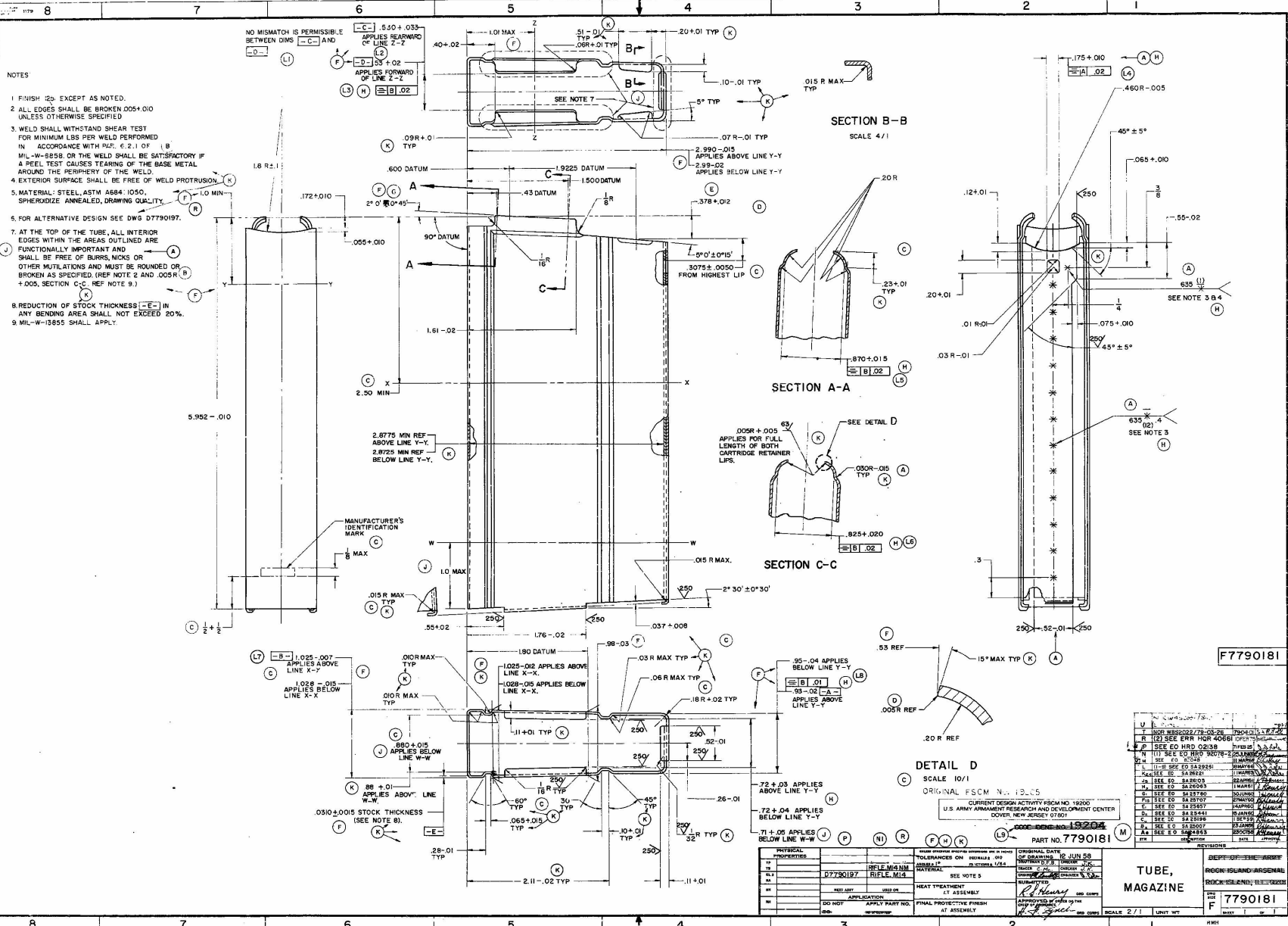
(C) 3. MIL-C-45404 APPLIES.

CODE IDENT NO. 19204

PART NO. 7790130

FOR LIST OF PARTS, SEE ENGR PARTS LIST 7790130

RIFLE, M21		PHYSICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED		ORIGINAL DATE OF DRAWING 15 JAN 58		DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILL. 61201	
A12002927 RIFLE, M14		YP		DIMENSIONS ARE IN INCHES		DRAFTSMAN <i>AW</i>	CHECKER <i>B. S. S.</i>		
M14 NM,		TS		TOLERANCES ON FRACTIONS DECIMALS ANGLES		TRACER <i>AW</i>	CHECKER <i>B. S. S.</i>		
M14A1, M14 (M)		EL2		MATERIAL		ENGR <i>AW</i>	ENGR <i>B. S. S.</i>		
NEXT ASSY		RA		HEAT TREATMENT		SUBMITTED		CLIP, CARTRIDGE, 7.62-MM, 5 ROUND	
USED WITH		BH		FINAL PROTECTIVE FINISH		APPROVED BY ORDER OF THE			
APPLICATION		RH		SEE NOTE 1		CHIEF OF OPERATIONS			
DO NOT	APPLY PART NO.					SCALE 4/1		UNIT WT. .018 LB	
DO-	AS SPECIFIED							DWD SIZE B 7790130 SHEET 1 OF 1	



REF SA-838029

6 5 4 3 2 1

NOTES:  
 1. MIL-W-13855 SHALL APPLY.  
 2. EACH MAGAZINE ASSEMBLY SHALL BE CAPABLE OF WITHSTANDING A 20 ROUND FUNCTION FIRING TEST WHEN FIRED IN THE M14A1 RIFLE WITHOUT MAL-FUNCTION ATTRIBUTABLE TO THE MAGAZINE. AFTER FIRING THE 20th ROUND FROM THE MAGAZINE, THE MAGAZINE FOLLOWER SHALL ACTUATE THE WEAPONS BOLT CATCH TO HOLD THE BOLT IN THE OPEN POSITION.

A  
C2

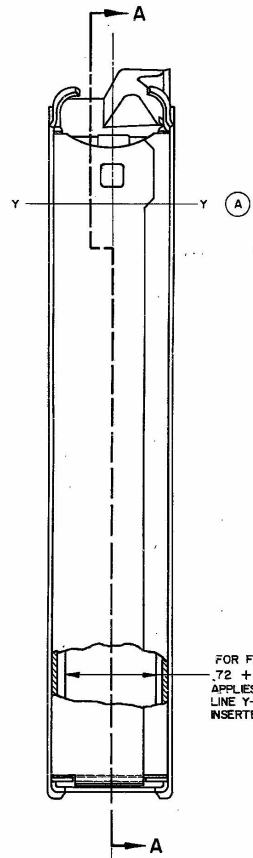
FOLLOWER ASSEMBLY - 7267019

SPRING - 7267078

TUBE ASSEMBLY - 7790197

BASE - 7790182

SECTION A-A



FOR FRONT RIB  
 .72 + .04  
 APPLIES BELOW  
 LINE Y-Y WITH BASE  
 INSERTED.

ORIGINAL DESIGN ACTIVITY FROM NO. 19200  
 CURRENT DESIGN ACTIVITY FROM NO. 19200  
 U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
 DOVER, NEW JERSEY 07801

G	NDRWHS2051/840924 ECP WSS2063/RS1223 ECP W402001/840218	960121	MR
CT	NDR WSS2022/79-05-26 790401	SA	7790183
CE	SEE EO HRD 02138	790401	7790183
CD	(1) SEE EO HRD 02138-2	790401	7790183
BC	(1) SEE EO 82048	790401	7790183
B	SEE EO 3A29561	790401	7790183
AA	SEE EO 3A29561	790401	7790183
STA	DESCRIPTION	DATE	APPROVAL

SEE SEPARATE PARTS LIST 7790183

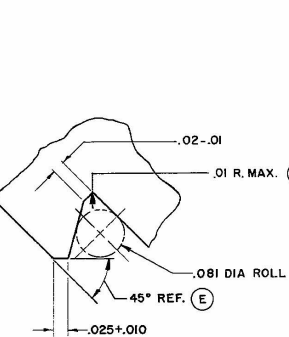
CODE IDENT NO. 19204  
 PART NO. 7790183

PHYSICAL PROPERTIES	TOLERANCES ON DECIMALS	ORIGINAL DATE OF DRAWING
Y2 J9386974 RIFLE M14NM	ANGLES	12 JUN 1958
Y3 F7267000 RIFLE M14	MATERIAL	DRAWN BY D.F.B. CHECKED J.K.
Y4	HEAT TREATMENT	TRACER G.S.S. CHECKER J.K.
Y5	FINAL PROTECTIVE FINISH	ENGINEER G.S.S.
Y6		
Y7		
Y8		
Y9		
Y10		
Y11		
Y12		
Y13		
Y14		
Y15		
Y16		
Y17		
Y18		
Y19		
Y20		

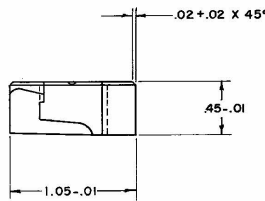
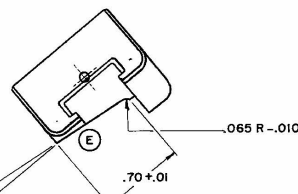
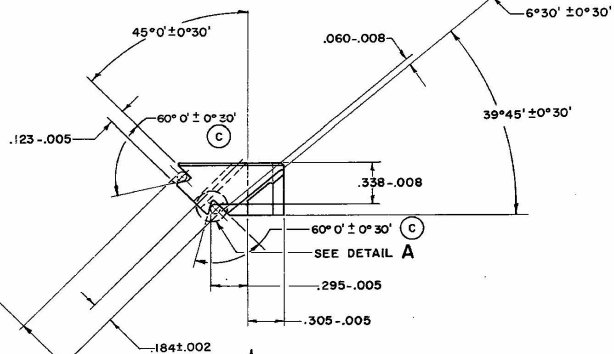
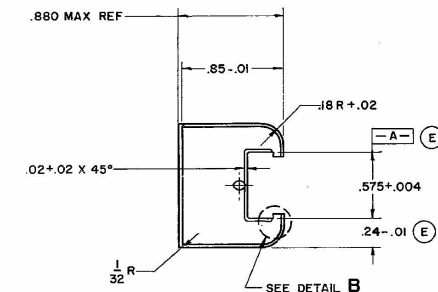
MAGAZINE  
 ASSEMBLY

DEPT OF THE ARMY	7790183
U.S. ARMY WEAPONS COMMAND	
ROCK ISLAND, ILL. 61201	
DATE	
SHEET	
OF	
RWH	

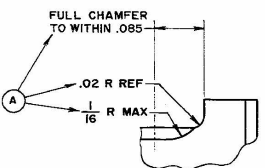
- NOTES:
1. FINISH 125/
  2. ALL EDGES SHALL BE BROKEN .005+ .010 UNLESS OTHERWISE SPECIFIED.
  3. MATERIALS:  
A- FOR WROUGHT MATERIAL:  
STEEL, SPEC ASTM A304 (E) (G2)  
A322, A331:4140, 8620,  
4140 RESULPHURIZED  
(SULPHUR .05 TO .09%) OR 4140  
LEADED (LEAD .15 TO .35%).  
B- FOR PRECISION CASTING:  
STEEL, MIL-S-22411:IC-8620.  
TENSILE TEST SHALL NOT APPLY.
  4. CLASSIFICATION AND INSPECTION OF INVESTMENT CASTINGS TO BE IN ACCORDANCE WITH CLASS 4, GRADE B, MIL-STD-2175.
  5. HEAT TREATMENT: FOR MATERIAL 4140 (A) HEAT AT 1575° TO 1600° F. IN NEUTRAL SALT BATH. QUENCH IN CIRCULATING OIL. TEMPER 30 MIN. AT HEAT TO ROCKWELL C40-45. FOR MATERIAL 8620 (A & B): CARBURIZE AT 1575° TO 1600° F. FROM .005 TO .008 DEPTH. QUENCH IN CIRCULATING OIL. TEMPER 30 MIN. AT 375° F. HARDNESS: FILE HARD. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED. THE USE OF STRAIGHT CYANIDE BATH OR CARBONITRIDING PROCESSES SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF THE CONTRACTING OFFICER.
  6. MIL-W-13855 SHALL APPLY.
  7. FINAL PROTECTIVE FINISH:  
FINISH 5.3.12 OR 5.3.2.2  
OF MIL-STD-171.



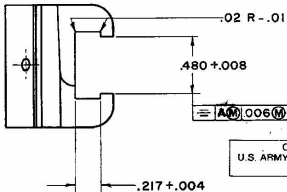
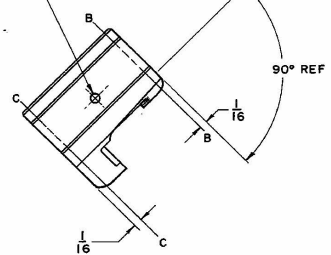
DETAIL A  
(BOTH SIDES)  
SCALE 10/1



467-.003 MEASURED AT B-B  
474-.003 MEASURED AT C-C



DETAIL B  
(BOTH CORNERS)  
SCALE 10/1



CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

ORIGINAL FSCM NO. 19205

PART NO. 7790184

PHYSICAL PROPERTIES	TOLERANCES ON DIMENSIONS	REMARKS
TP	F9352636	RIFLE, M14NM
TS	F7790191	RIFLE, M14
EL		
PA		
MT		
SE	SEE NOTE 5	
DO NOT	APPLY PART NO.	
GO		

ORIGINAL DATE OF DRAWING	APPROVED BY	DATE
10 JUL 58	R. S. Henry	10 JUL 58
	R. J. Lynch	

REVISIONS	DATE	APPROVAL
N (ECPW5S2066 / 651225)	650121	
M (NORW4S2051 / 540624)	79-04-01	
L (SEE ERR HQR 40681)	10FEB75	
K (U-2) SEE EO HRD 02138	71FEB75	
J (U-2) SEE EO HRD 02078-2	65JAN65	
H (U-2) SEE EO-82045	11MAY62	
G (U-3) SEE EO SA 29262	8MAY62	
F (U-3) SEE EO SA 27051	70FEB75	
E (U-3) SEE EO SA 26332	13MAY62	
D (U-3) SEE EO SA 25471	13MAY62	
C (U-3) SEE EO SA 25124	13MAY62	
B (U-3) SEE EO SA 25003	13MAY62	
A (U-3) SEE EO SA 24742	13MAY62	

GUIDE,  
CARTRIDGE CLIP

REVISIONS	DATE	APPROVAL
D	7790184	

R. M. H.

NOTES:

1. FINISH .125 EXCEPT AS NOTED.
2. ALL CORNERS AND EDGES SHALL BE ROUNDED OR BROKEN .006±.010 UNLESS OTHERWISE SPECIFIED.
3. ROCKWELL READINGS SHALL BE TAKEN ON LOCKING LUGS AND REAR END OF BOLT.
4. EACH LUG SHALL BE PERPENDICULAR WITHIN .0005 WITH AXIS ESTABLISHED BY .750 DIA-.002 AND .70 DIA-.002. GRINDING SHALL BE DONE RADUALLY.
5. MATERIAL: STEEL, COMPEN 8630H, EXCEPT RESURFURIZED (SULPHUR .035 TO .060%) RUN QUALITY, SPEC ASTM A304, A322, A331, HARDENABILITY OF STEEL SHALL BE CONTROLLED AS REQUIRED TO SUIT MANUFACTURER'S HEAT TREATMENT PROCESS AND ASSURE THAT SPECIFIED MANDATORY PHYSICAL PROPERTIES ARE MET. AUSTENITIC GRAIN SIZE 5 TO 6.
6. HEAT TREATMENT: RECOMMENDED PROCESS: NORMALIZE 1550°F FOR 1 HOUR, FOLLOWED BY TEMPERING AT NOT LESS THAN 450°F. MAY BE USED IN LIEU OF AIR COOLING. CARBURIZE AT 1550°F TO 1600°F TO SPECIFIED CASE DEPTH. WITHOUT REHEATING, QUENCH IN OIL OR NEUTRAL SALT BATH FROM 1500°F TO 1600°F; IF REHEATED, QUENCH FROM 1550°F TO 1600°F. TEMPER TO HARDNESS SPECIFIED.
7. MANDATORY REQUIREMENTS:
  - a. NORMALIZE BEFORE MACHINING.
  - b. CARBURIZE TO CASE DEPTH .012 TO .018.
  - c. TEMPER ONE HOUR MINIMUM AT 350°F TO 450°F.
  - d. CORE, ROCKWELL HARDNESS C33 TO C42, SURFACE HARDNESS D66-71 OR REFERENCE METHOD 30H-78 MINIMUM ON A PROPERLY PREPARED SURFACE.
  - e. MICROSTRUCTURE OF CORE SHALL NOT CONTAIN (a) (c) (f) MORE THAN 10% FREE FERRITE AFTER HEAT TREATMENT PER AMS 2752.
  - f. THE USE OF A STRAIGHT CYANIDE BATH OR CARBO-NITRIDING PROCESS SHALL NOT BE PERMITTED.
  - g. WHEN GAS CARBURIZING IS USED THE CARBON CONTENT SHALL NOT EXCEED 0.94% AT SURFACE OF COMPONENT PER AMS 2752.
8. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OF MIL-STD-171.
9. MIL-W-13855 SHALL APPLY.

SECTION A-A

SCALE: 20/1

VIEW E SEE ZONE D-3

SCALE: 20/1

SECTION C-C

SCALE: 20/1

VIEW D

SCALE: 10/1

SECTION R-R

SCALE: 10/1

DATA FOR HARDNESS TESTING

SCALE: NTS

SECTION B-B

SCALE: 4/1

SECTION D-D

SCALE: 4/1

SECTION E-E

SCALE: 4/1

SECTION F-F

SCALE: 4/1

SECTION G-G

SCALE: 4/1

SECTION H-H

SCALE: 4/1

SECTION I-I

SCALE: 4/1

SECTION J-J

SCALE: 4/1

SECTION K-K

SCALE: 4/1

SECTION L-L

SCALE: 4/1

DISTRIBUTION STATEMENTS  
APPROVED FOR PUBLIC RELEASE; DISTRIBUTION IS UNLIMITED

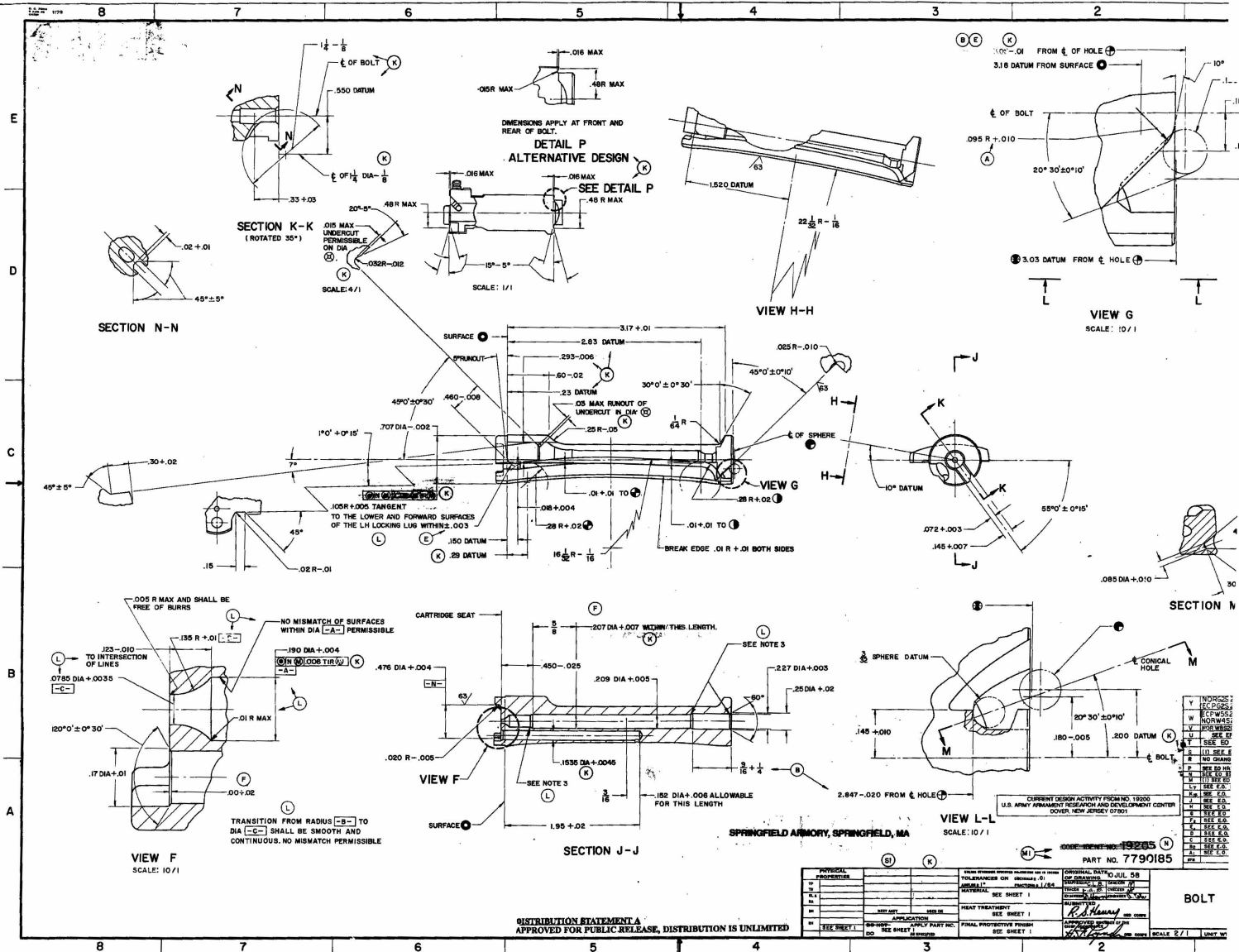
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3	3.1	3.1.1	3.1.1.1	3.1.1.1.1
4	4.1	4.1.1	4.1.1.1	4.1.1.1.1
5	5.1	5.1.1	5.1.1.1	5.1.1.1.1
6	6.1	6.1.1	6.1.1.1	6.1.1.1.1
7	7.1	7.1.1	7.1.1.1	7.1.1.1.1
8	8.1	8.1.1	8.1.1.1	8.1.1.1.1
9	9.1	9.1.1	9.1.1.1	9.1.1.1.1
10	10.1	10.1.1	10.1.1.1	10.1.1.1.1

REVISION	DATE	BY	CHKD	APP'D	REMARKS
1	10 JUL 58	1	1	1	1
2	10 JUL 58	2	2	2	2
3	10 JUL 58	3	3	3	3
4	10 JUL 58	4	4	4	4
5	10 JUL 58	5	5	5	5
6	10 JUL 58	6	6	6	6
7	10 JUL 58	7	7	7	7
8	10 JUL 58	8	8	8	8
9	10 JUL 58	9	9	9	9
10	10 JUL 58	10	10	10	10

REVISION	DATE	BY	CHKD	APP'D	REMARKS
1	10 JUL 58	1	1	1	1
2	10 JUL 58	2	2	2	2
3	10 JUL 58	3	3	3	3
4	10 JUL 58	4	4	4	4
5	10 JUL 58	5	5	5	5
6	10 JUL 58	6	6	6	6
7	10 JUL 58	7	7	7	7
8	10 JUL 58	8	8	8	8
9	10 JUL 58	9	9	9	9
10	10 JUL 58	10	10	10	10

BOLT  
SPRINGFIELD ARMOY  
US ARMY WEAPONS  
CORPS  
SPRINGFIELD, MASS  
7790185





PHYSICAL PROPERTIES	APPROVALS	ORIGINAL DATE	REVISION
1. MATERIAL	1. APPROVED	1. DATE	1. REVISION
2. HEAT TREATMENT	2. APPROVED	2. DATE	2. REVISION
3. FINISH	3. APPROVED	3. DATE	3. REVISION
4. DIMENSIONS	4. APPROVED	4. DATE	4. REVISION
5. TOLERANCES	5. APPROVED	5. DATE	5. REVISION
6. SURFACE FINISH	6. APPROVED	6. DATE	6. REVISION
7. WEIGHT	7. APPROVED	7. DATE	7. REVISION
8. OTHER	8. APPROVED	8. DATE	8. REVISION

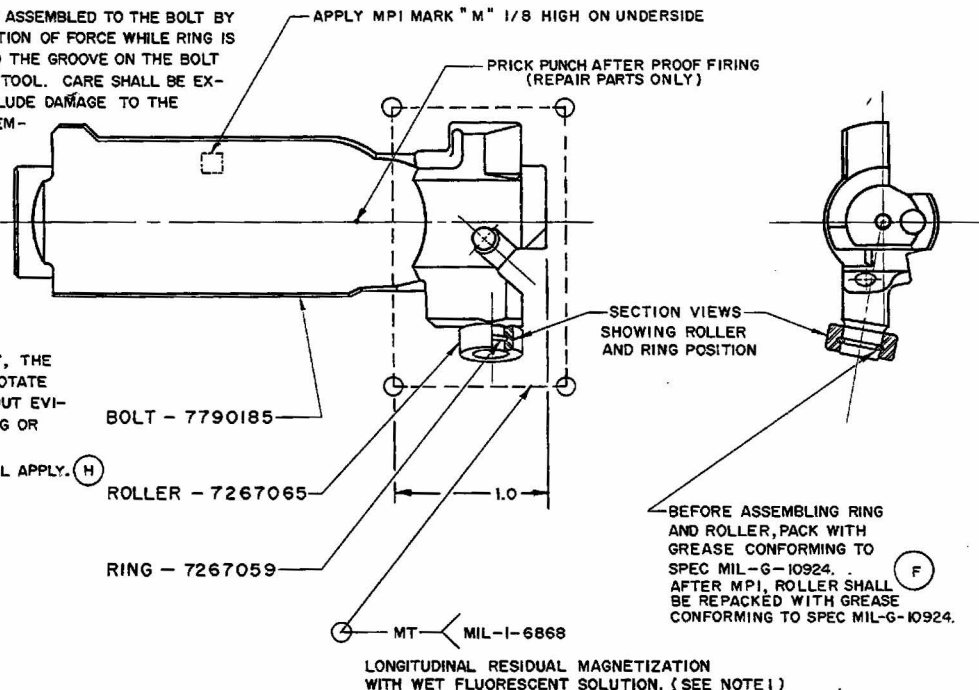
NOTES:

1. EACH REPAIR PART BOLT AND ROLLER ASSY SHALL WITHSTAND THE FIRING OF ONE GOVERNMENT STANDARD HIGH PRESSURE TEST CARTRIDGE WITHOUT EVIDENCE OF FAILURE AS DETERMINED BY MAGNETIC PARTICLE INSPECTION FOR CRACKS, SEAMS AND OTHER INJURIOUS DEFECTS, USING A STANDARD 5 TURN MAGNETIZING COIL WITH A CURRENT OF 200 TO 250 AMPERES. APPLY MPI MARK TO ASSY MEETING THIS REQUIREMENT.

2. ROLLER SHALL BE ASSEMBLED TO THE BOLT BY GRADUAL APPLICATION OF FORCE WHILE RING IS COMPRESSED INTO THE GROOVE ON THE BOLT WITH A SUITABLE TOOL. CARE SHALL BE EXERCISED TO PRECLUDE DAMAGE TO THE RING DURING ASSEMBLY OPERATION.

3. AFTER ASSEMBLY, THE ROLLER SHALL ROTATE SMOOTHLY WITHOUT EVIDENCE OF BINDING OR DRAG.

4. MIL-W-13855 SHALL APPLY. (H)



BEFORE ASSEMBLING RING AND ROLLER, PACK WITH GREASE CONFORMING TO SPEC MIL-G-10924. AFTER MPI, ROLLER SHALL BE REPACKED WITH GREASE CONFORMING TO SPEC MIL-G-10924. (F)

LONGITUDINAL RESIDUAL MAGNETIZATION WITH WET FLUORESCENT SOLUTION. (SEE NOTE 1)

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

ENGINEERING NO. 19203

DISTRIBUTION STATEMENT A

APPROVED FOR PUBLIC RELEASE. DISTRIBUTION IS UNLIMITED

(G1) (H)

FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 7790186

PHYSICAL PROPERTIES	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	TOLERANCES ON DECIMALS	ORIGINAL DATE OF DRAWING
TP	RIFLE, M14NM	ASSEMBLY	10 JUL 58
TP		FRACTIONS	
CL 2	C 7790187 RIFLE, M14	MATERIAL	
RA		HEAT TREATMENT	
BR	TEST ASSY	USED ON	
EN	APPLICATION	FINAL PROTECTIVE FINISH	
EN	DO NOT APPLY PART NO.		
GO	44-48999-2		

ENGINEER	CHECKED	DATE
DESIGNED BY	CHECKED	
APPROVED BY	CHECKED	
APPROVED BY	CHECKED	
APPROVED BY	CHECKED	

BOLT AND ROLLER  
ASSEMBLY

SCALE 2/1 UNIT WT

SPRINGFIELD ARMOY

SPRINGFIELD ARMOY

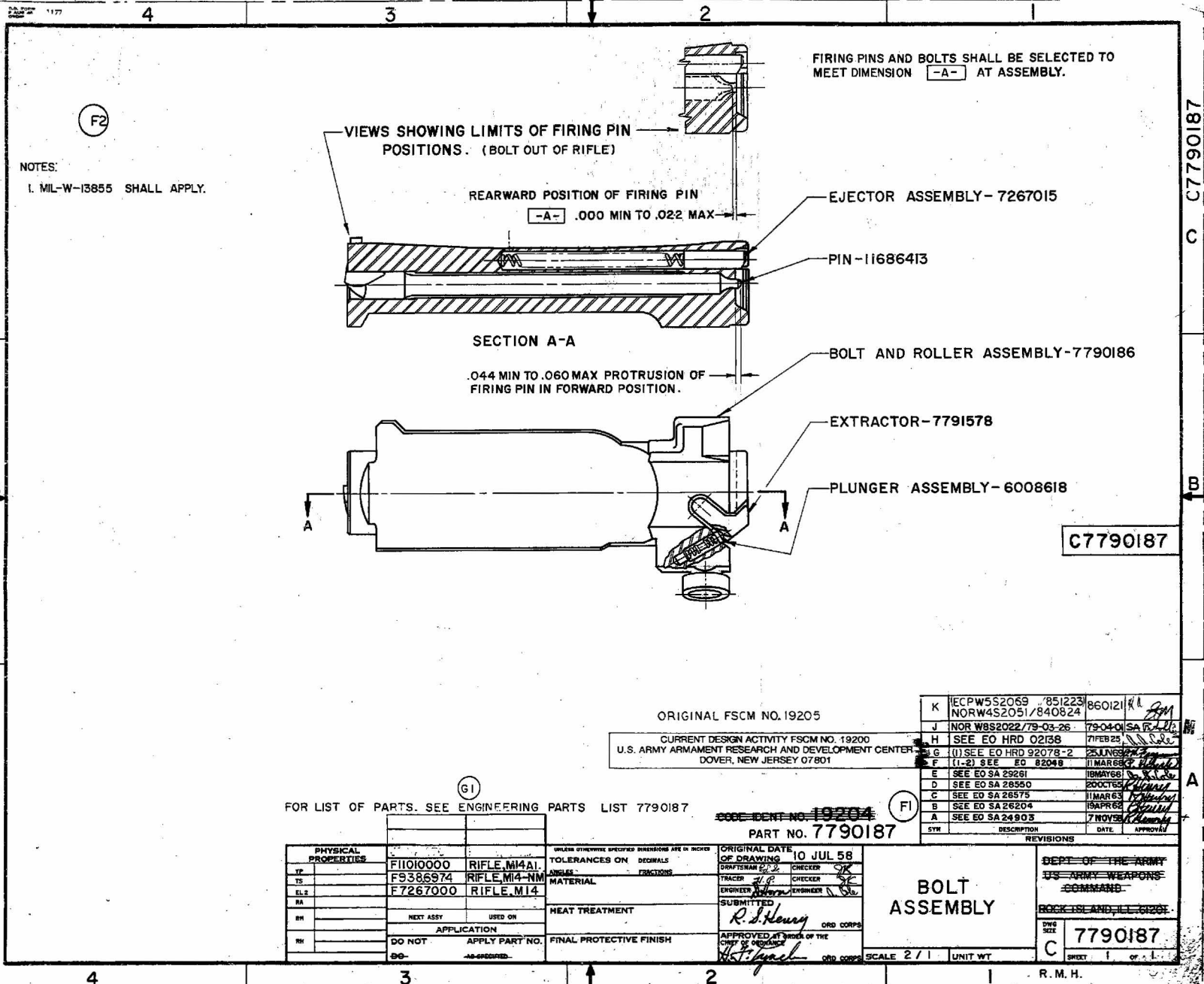
DWG NO. 7790186  
C

L	NORC2S2038/921021	921230	SA
K	ECPW552065/7651223	86012	SA
J	NORW452051/840824	79040	SA
H	SEE EO HRD 02138	71FEB25	SA
G	(U) SEE EO HRD 92078-2	25 JUN 87	SA
F	SEE EO RIA-14182	18 MAY 67	SA
E	SEE EO SA 29281	18 MAY 66	SA
D	SEE EO SA 26910	26 AUG 63	SA
C	SEE EO SA 26046	15 FEB 61	SA
B	SEE EO SA 25810	30 SEP 60	SA
A	SEE EO SA 25232	1 SEP 59	SA
SYM	DESCRIPTION	DATE	APPROVAL

C 7790186

C 7790186

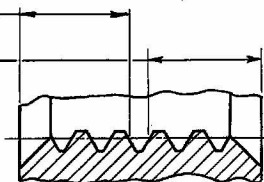
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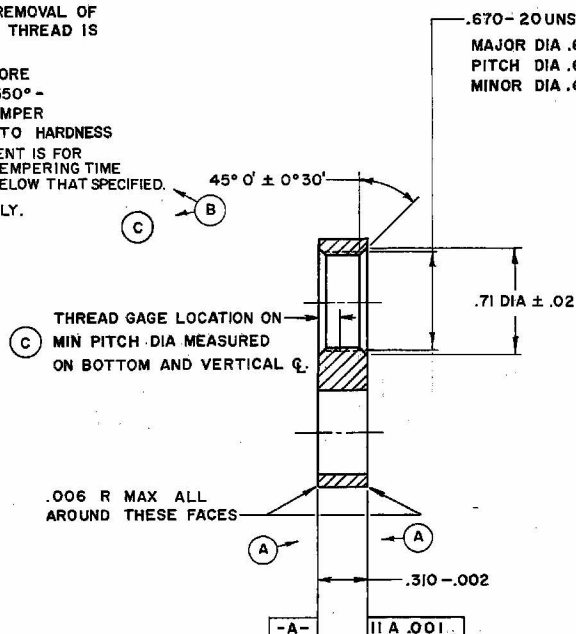
NOTES:

1. FINISH  $\sqrt{63}$  EXCEPT AS NOTED.
2. ALL EDGES SHALL BE BROKEN .01+.01 UNLESS OTHERWISE SPECIFIED.
3. REMOVAL OR PARTIAL REMOVAL OF PROTECTIVE FINISH ON THREAD IS PERMISSIBLE.
4. HEAT TREATMENT: BEFORE MACHINING, HEAT TO 1550°-1575°F. OIL QUENCH. TEMPER 45 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
5. MIL-W-13855 SHALL APPLY.

.142 ± .002 LOCATION OF GAGE  
SHALL BE WITHIN RESULTANT  
DIMENSIONAL LIMITS



PARTIAL SECTION OF .670-20UNS-3B THD.  
SCALE: 10/1



SECTION A-A

ORIGINAL FSCM NO. 19205

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

CODE IDENT NO. 19204  
PART NO. 7790188

J	ECPW5S2069 /851223	860121	1/2 R
H	NORW4S2051/ 840824	790401	SA 07/22
G	SEE EO HRD 02138	790401	SA 07/22
F	(1) SEE EO HRD 92078-2	25 JUN 85	SA 07/22
E	SEE EO 82048	11 MAR 85	SA 07/22
D	(1-3) SEE EO SA 29261	18 MAY 85	SA 07/22
C	SEE EO SA 26177	18 MAR 85	SA 07/22
B	SEE EO SA 25568	23 DEC 84	SA 07/22
A	SEE EO SA 25470	28 DEC 84	SA 07/22
SYN	DESCRIPTION	DATE	APPROVAL

PHYSICAL PROPERTIES	APPLICATION
YP	J9386974
TS	RIFLE, M14, NM
SLZ	F7267000
RA	RIFLE, M14
BH	NEXT ASSY USED ON
RH	C28-33
DO NOT	APPLY PART NO.

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES  
TOLERANCES ON DECIMALS  
ANGLES FRACTIONS  
MATERIAL STEEL, SPEC ASTM  
A304, A322, A331; 4150  
HEAT TREATMENT  
SEE NOTE 4  
FINAL PROTECTIVE FINISH  
FINISH NO. 3.3.1.2 OF MIL-STD-171

ORIGINAL DATE OF DRAWING 10 JUL 1958+  
DRAFTSMAN J.E. CHECKER J.K.  
TRACER R.J. CHECKER J.K.  
ENGINEER J.K. ENGINEER J.K.  
SUBMITTED  
R.D. Henry ORG CORPS  
APPROVED BY ORDER OF THE  
CHIEF OF ORDNANCE  
A.J. Lynch ORG CORPS

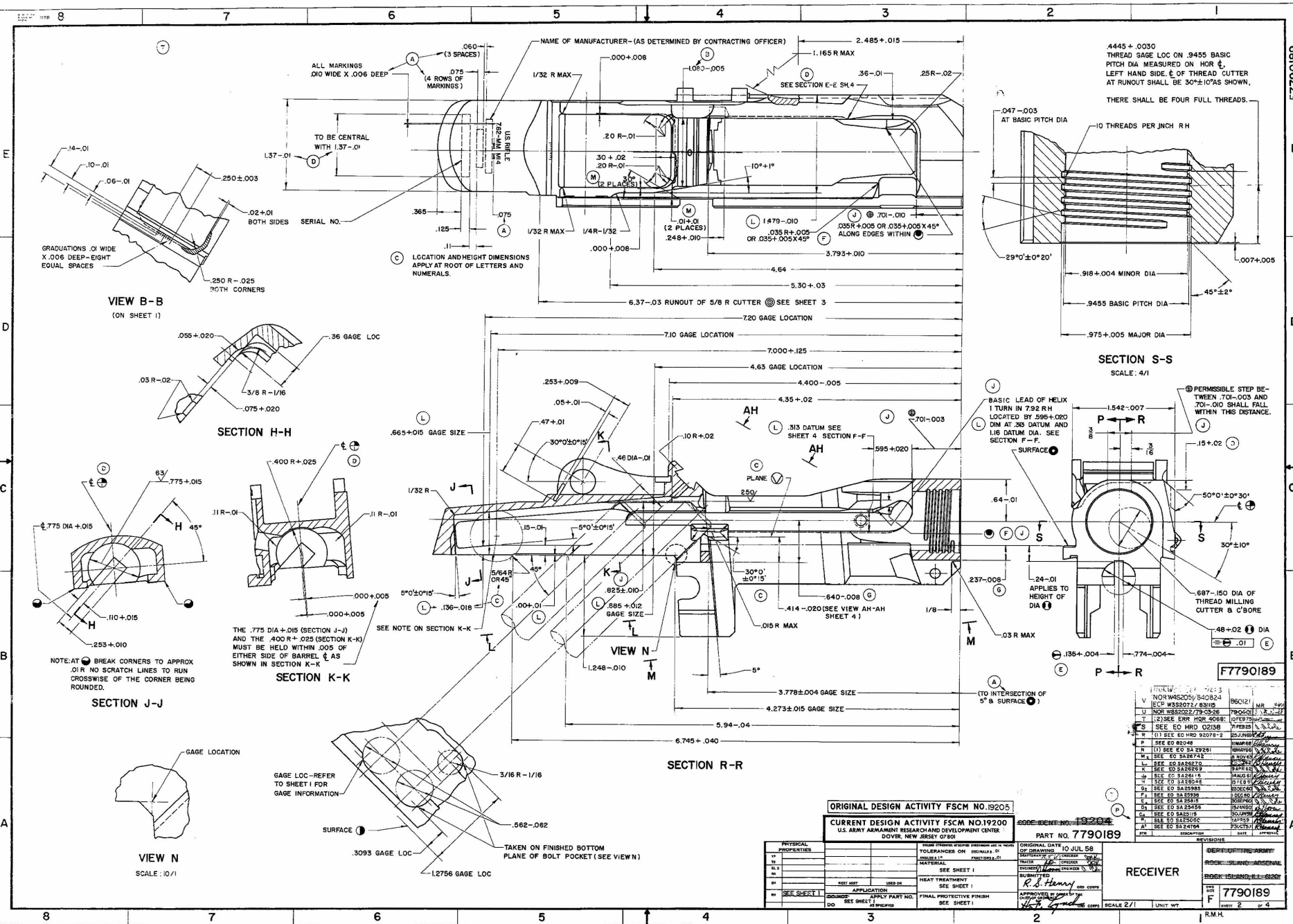
LOCK, GAS  
CYLINDER

DEPT OF THE ARMY  
U.S. ARMY WEAPONS  
COMMAND  
ROCK ISLAND, ILL 61201

OWC  
SIZE  
7790188  
C  
SHEET 1 OF 1

R.M.H.





ORIGINAL DESIGN ACTIVITY FSCM NO. 19205

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

PART NO. 7790189

PHYSICAL PROPERTIES	DESIGN PROPERTIES	ORIGINAL DATE OF DRAWING	REVISION
1. MATERIAL	2. TOLERANCES ON DIMENSIONS	10 JUL 58	1. REVISION
2. HEAT TREATMENT	3. FINISH		2. REVISION
3. APPLICATION	4. HEAT TREATMENT		3. REVISION
4. DO	5. FINISH		4. REVISION

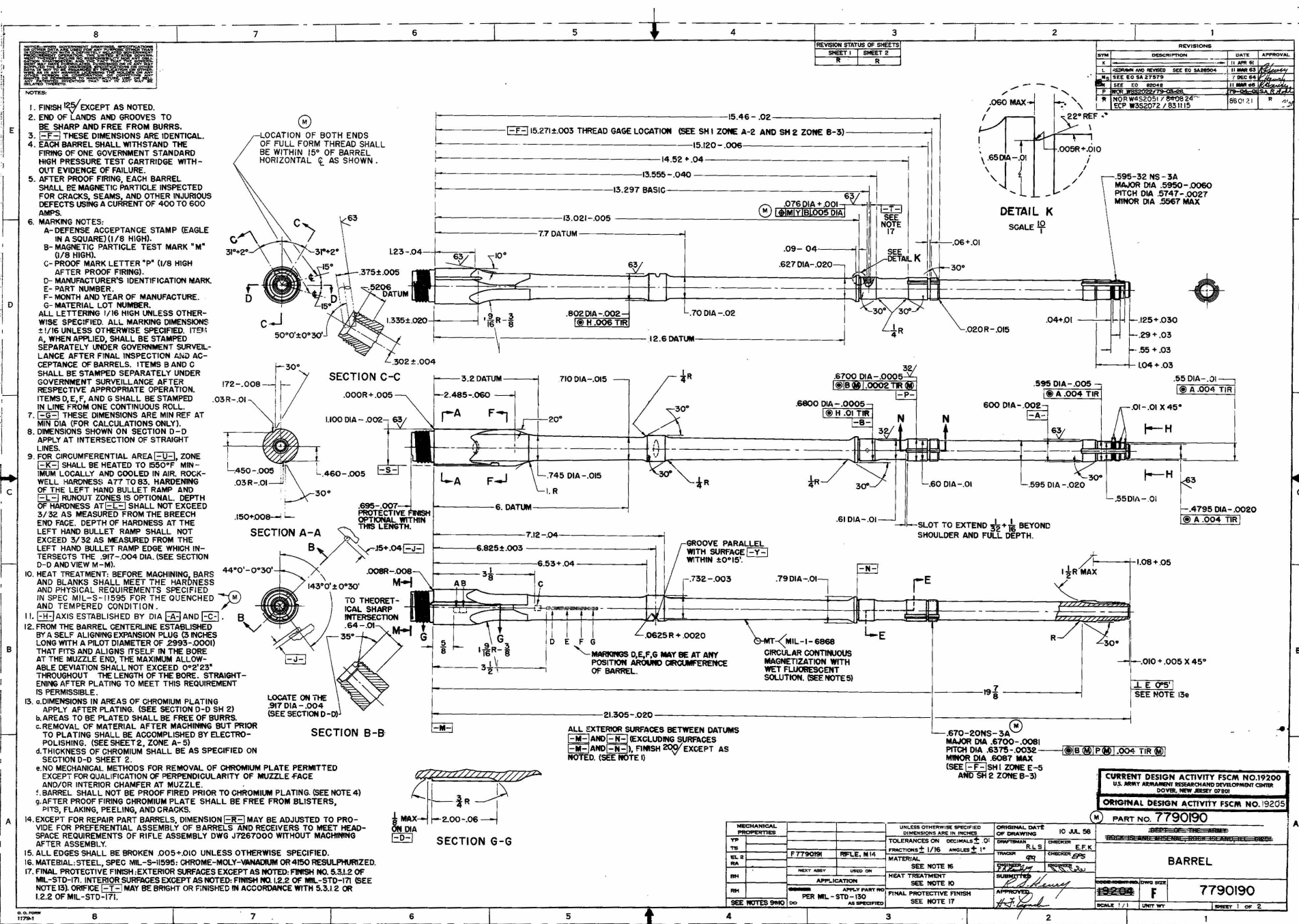
RECEIVER

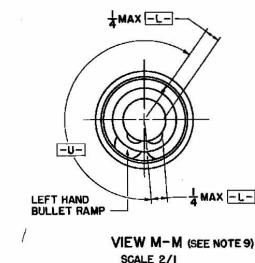
7790189
SCALE 2/1
UNIT WT
R.M.H.











8

7

6

5

4

2

1

1

**F**

—

—GUIDE-7790184

—BARREL-7790190

1

C

11

A

8

7

6

5

4

3

2

\_\_\_\_\_

5

1

1

4

90°0' ± 0°20'  
(SEE NOTE I)

4-HORIZONTAL & RECEIVER

VERTICAL & BARREL

- TAP PIN LIGHTLY TO FLARE OUT  
END AS SHOWN. LATERAL  
MOVEMENT OF PIN-7267035 SHALL  
NOT BE IMPEDED.

SECTION A-A

SCALE 4/1

**PIN-7267035**

PIN-7267042

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND  
DOVER, NEW JERSEY 07801

CODE IDENT NO.
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19200

~~CONFIDENTIAL~~ IDENT NO 1920

PART NO. 779015

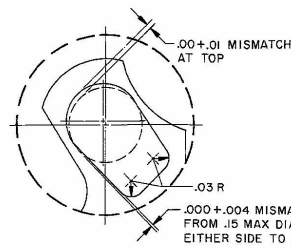
FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 779019

PHYSICAL PROPERTIES		WEIGHT INFORMATION (WEIGHTS, DIMENSIONS, OR IN PLACE TOLERANCES ON DRAWING)		ORIGINAL DATA DATE OF DELIVERY: 10 JUL 58 DRAWING NO: 100-100000-1 DRAWING BY: J. H. HANNEY CHECKED BY: J. H. HANNEY APPROVED BY: J. H. HANNEY REVIEWED BY: J. H. HANNEY		REVISIONS	
1. ID		MATERIAL FACTORIES				SHEET OF 1	
2. L	F7267000 RIFLE, M14	MATERIAL				SHEET OF 1	
3. W	SEE ENGINE RECORDS	HEAT TREATMENT				SHEET OF 1	
4. H	SEE ENG. 100-100000-1	APPLICATION				SHEET OF 1	
5. D	DO NOT APPLY PART NO.	FINAL PROTECTIVE FINISH				SHEET OF 1	
DO-100-100000-1						SCALE 1/1 UNIT WT	
						F 7790191	

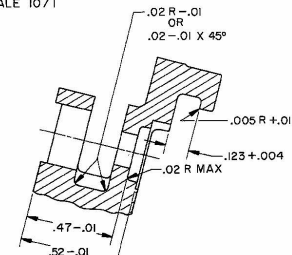
NO. OF VIEWS	POSITION NUMBERS	NUMBER OF POSITIONS	NO. OF VIEWS PER FILM	FILM SIZE
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# NOTES:

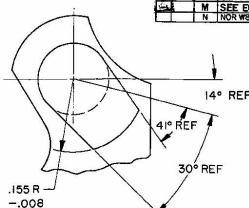
- FINISH <sup>125</sup> EXCEPT AS NOTED.
- ALL EDGES SHALL BE BROKEN .005+-.025 UNLESS OTHERWISE SPECIFIED.
- MATERIAL:
  - FOR WROUGHT MATERIAL: STEEL, COMP B615, SPEC ASTM A304, A322, A331.
  - FOR PRECISION CASTING: STEEL, COMP IC8620, MIL-S-22141, EXCEPT: CARBON .10 TO .20 PERCENT. TENSILE TEST SHALL NOT APPLY.
- HEAT TREATMENT: CARBURIZE AT 1575°-1600° F FROM .005 TO .008 DEPTH. OIL QUENCH. TEMPER 30 MIN AT 375° F. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED. THE USE OF STRAIGHT CYANIDE BATH OR CARBO-NITRIDING PROCESS SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF THE CONTRACTING OFFICER.
- MIL-W-13855 SHALL APPLY. (M)
- CLASSIFICATION AND INSPECTION OF INVESTMENT CASTINGS TO BE IN ACCORDANCE WITH CLASS I, GRADE A, SPEC MIL-C-6021.



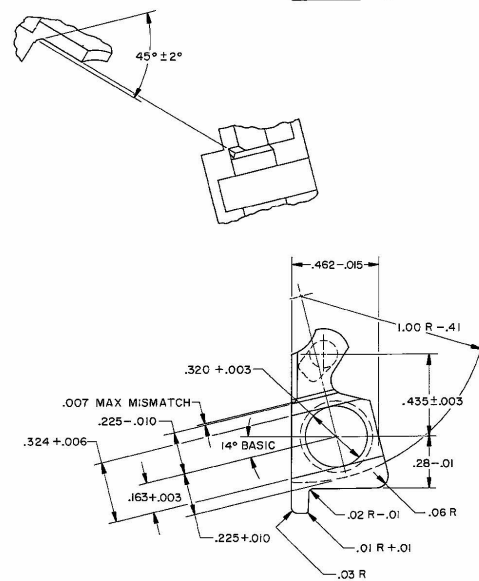
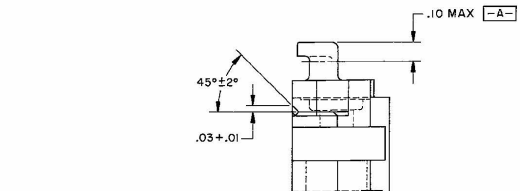
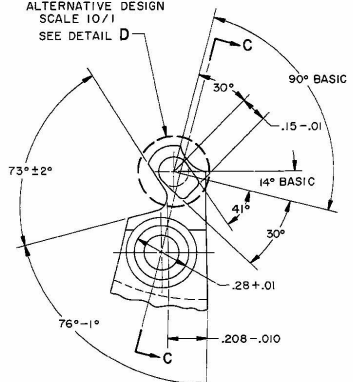
DETAIL D  
SCALE 10/1



SECTION C-C



ALTERNATIVE DESIGN  
SCALE 10/1  
SEE DETAIL D



SEE NOTE 6 RT

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND  
DOVER, NEW JERSEY 07801

PART NO. 7790192  
CODE IDENT NO. 19200

MECHANICAL PROPERTIES	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	ORIGINAL DATE OF DRAWING
1P	TOLERANCES UNLESS OTHERWISE SPECIFIED	10 JUL 58
TS	ANGLES ± 1°	RLS EJK
EL 2	MATERIAL	SEE NOTE 3
SA	HEAT TREATMENT	SEE NOTE 4
SH	FINISH	FINISH 5.3.1.2 OF MIL-STD-71
SK	FILED	

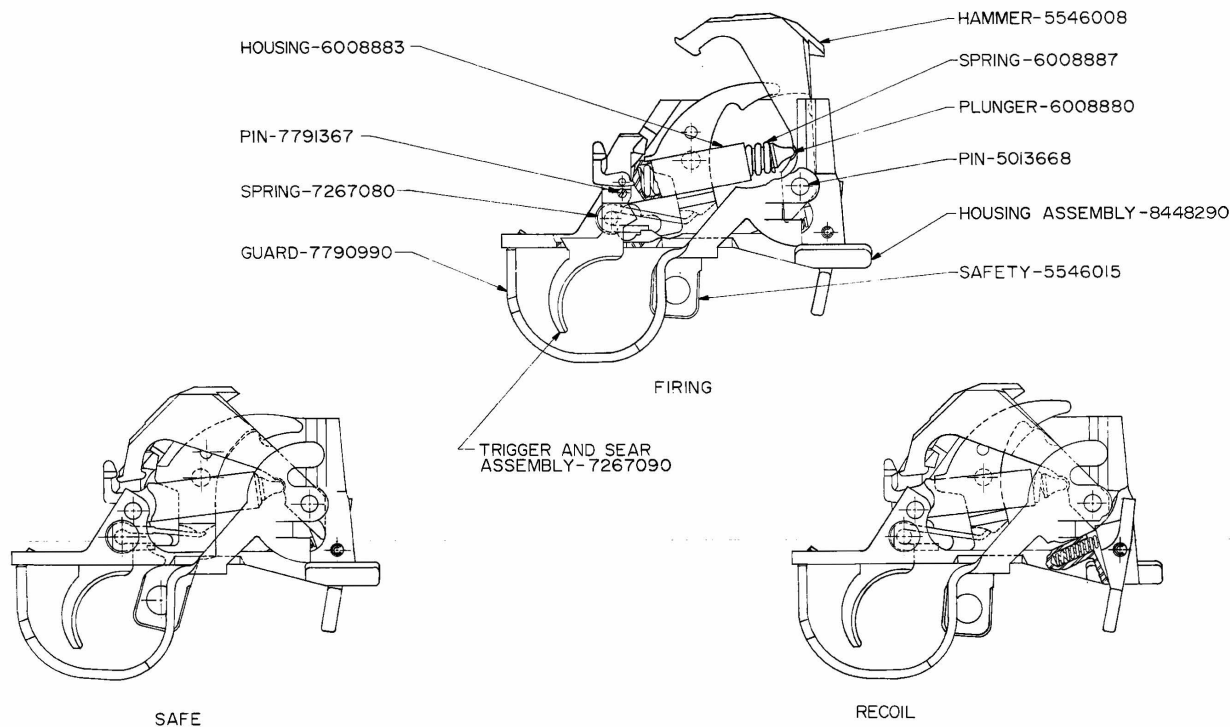
RELEASE, SEAR
7790192
SCALE 4/1 UNIT WT

6 5 4 3 2 1

REVISIONS			
BY	DESCRIPTION	DATE	APPROVAL
K	REDRAWN WITH CHANGE, ERR 2921042L (ECP 0953062 89-07-18)	90-08-27	<i>[Signature]</i>

NOTES

1. APPLICABLE STANDARDS / SPECIFICATIONS:  
A. DOD-STD-00100D (AR)  
B. ANSI Y14.5M-1982  
C. MIL-W-13855



CURRENT DESIGN ACTIVITY CASE CODE 19400  
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER  
FIGHTING SPECIAL, NEW JERSEY 07063-5000

PART NO. 7790195  
DEPT. OF THE ARMY  
SPRINGFIELD ARMOY, SPRINGFIELD, MA

F7267000		REF. MM	DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 58-07-10	
NEXT ASST		USED ON	TOLERANCES ON DECIMALS & FRACTIONS & ANGLES & THIRD ANGLE PROJECTION		DRAWN BY J. BRIGHTLER CHECKED BY D. HORN A. COLE	
APPLICATION					R.S. HENRY H.F. LYNCH	
					SIZE FROM NO. F 19205 7790195 SCALE 2/1 UNIT WT.	





NOTICE—WHEN GOVERNMENT DRAWINGS SPECIFICATIONS OR OTHER DATA ARE USED FOR ANY PURPOSE OTHER THAN IN CONNECTION WITH A DEFINITELY RELATED GOVERNMENT PROCUREMENT OPERATION, THE UNITED STATES GOVERNMENT HEREBY INCURS NO RESPONSIBILITY NOR ANY OBLIGATION WHATSOEVER, AND THE FACT THAT THE GOVERNMENT MAY HAVE FORMULATED, FURNISHED OR IN ANY WAY SUPPLIED THE SAID DRAWINGS, SPECIFICATIONS OR OTHER DATA IS NOT TO BE REGARDED BY IMPLICATION OR OTHERWISE AS IN ANY MANNER LICENSING THE HOLDER OR ANY OTHER PERSON OR CORPORATION, OR CONVEYING ANY RIGHTS OR PERMISSION TO MANUFACTURE, USE, OR SELL ANY PATENTED INVENTION THAT MAY IN ANY WAY BE RELATED THERETO.

NOTES:

1. MATERIAL: POLYETHYLENE, TYPE I, CLASS L, GRADE 1 OR 2 OF L-P-390. (E)

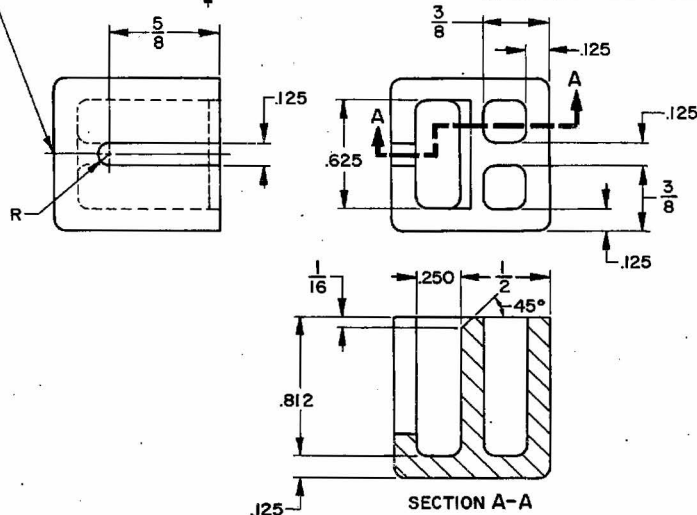
COLOR — NATURAL  
FINISH — SMOOTH

2. PARTS SHALL BE FREE OF WARP, CRACKS, BLISTERS, UNEVEN SURFACES, FINS, BURRS, AND PROJECTING RIDGES. BUFFING MAY BE EMPLOYED AS NECESSARY.

3. ALL EDGES AND FILLETS  $\frac{1}{16}$  R MAX UNLESS OTHERWISE INDICATED:

APPLY PART NO.  
ON THIS SURFACE

7790231



REVISIONS

SYM	DESCRIPTION	DATE	APPROVAL
C		4 MAR 64	
D	REDRAWN & REVISED SEE EO SA27456	15 MAY 64	<i>[Signature]</i>
E <sub>3</sub>	SEE HQP-31608	1 FEB 73	<i>[Signature]</i>

PART NO. 7790231 (E)



MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 10 JUL 58		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON DECIMALS $\pm .010$		DRAFTSMAN	CHECKER	PROTECTOR, HANDLE	
TS		FRACTIONS $\pm 1/32$ ANGLES $\pm 1^\circ$		RSB	RMM		
EL 2	D8449427	MATERIAL SEE NOTE 1		TRACER RRP	CHECKER GJ		
RA	SEE ENGINEERING RECORDS	HEAT TREATMENT		ENGINEER R. Sullivan	ENGINEER R. Sullivan		
BH	NEXT ASSY USED ON	FINAL PROTECTIVE FINISH		SUBMITTED		CODE IDENT NO. DWG SIZE	
RH	APPLICATION			APPROVED		00000 B 7790231	
DO NOT PER MIL-STD-130				VA [Signature]		SCALE 2/1 UNIT WT .014 LB SHEET 1 OF 1	

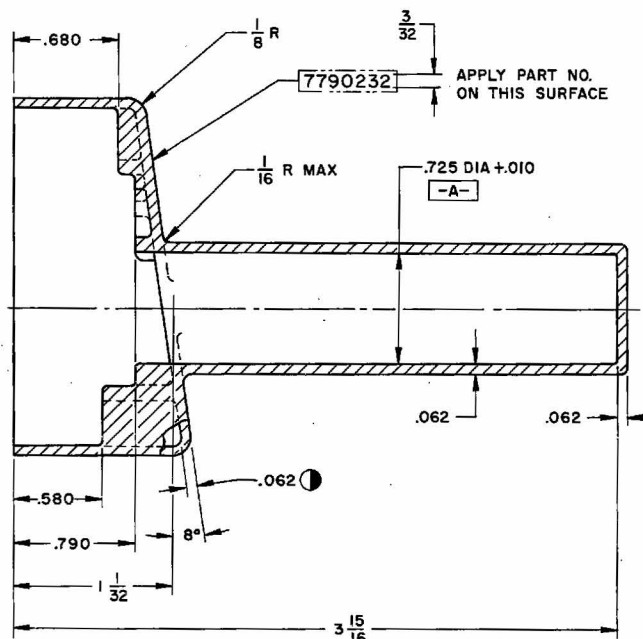
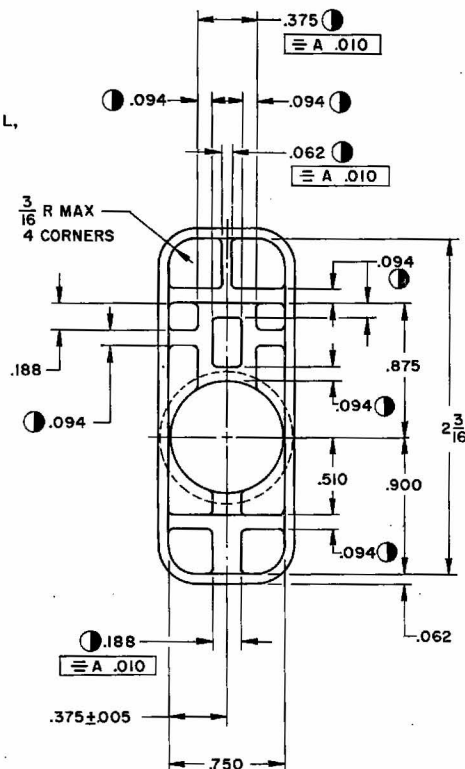
SWESP 1176-1  
28 AUG 62

PDC

NOTICE: WHEN GOVERNMENT DRAWINGS SPECIFICATIONS OR OTHER DATA ARE USED FOR ANY PURPOSE OTHER THAN IN CONNECTION WITH A DEFINITELY RELATED GOVERNMENT PROCUREMENT OPERATION, THE UNITED STATES GOVERNMENT THEREBY INCURS NO RESPONSIBILITY NOR ANY OBLIGATION WHATSOEVER, AND THE INDIATOR OF THE GOVERNMENT MAY HAVE FORMULATED, FURNISHED, OR OTHERWISE SUPPLIED THE SAID DRAWINGS, SPECIFICATIONS OR OTHER DATA IS NOT TO BE REGARDED BY IMPLICATION OR OTHERWISE AS IN ANY MANNER LICENSING THE HOLDER OR ANY OTHER PERSON FOR REPRODUCTION OR CONVEYING ANY RIGHTS OR PERMISSION TO MANUFACTURE, USE OR SELL ANY PATENTED INVENTION THAT MAY IN ANY WAY BE RELATED THERETO.

# NOTES:

1.  CORING IS OPTIONAL. DIMENSIONS SHOWN ARE MINIMUM.
2. ALL INSIDE EDGES AND FILLETS  $\frac{1}{32}$  R MAX UNLESS OTHERWISE INDICATED.
3. MATERIAL: POLYETHYLENE, TYPE I, CLASS L, GRADE 1 OR 2 OF L-P-390. COLOR NATURAL  FINISH SMOOTH
4. PARTS SHALL BE FREE OF WARP, CRACKS, BLISTERS, UNEVEN SURFACES, FINS, BURRS, AND PROJECTING RIDGES. BUFFING MAY BE EMPLOYED AS NECESSARY.



REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
D		8 NOV 63	
E	REDRAWN & REVISED SEE EO SA 27456	15 MAY 64	<i>[Signature]</i>
F	SEE HQP-31608	1 FEB 73	<i>[Signature]</i>

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 10 JUL 58		DEPT OF THE ARMY	
YP		TOLERANCES ON DECIMALS $\pm .010$		DRAFTSMAN RSB		ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
TS		FRACTIONS $\pm \frac{1}{32}$ ANGLES $\pm 1^\circ$		TRACER <i>[Signature]</i>		CHECKER RMM	
EL 2	D8449427	MATERIAL SEE NOTE 3		ENGINEER <i>[Signature]</i>		CHECKER <i>[Signature]</i>	
RA	SEE ENGINEERING RECORDS	HEAT TREATMENT		SUBMITTED		PROTECTOR, MUZZLE	
BH	NEXT ASSY USED ON APPLICATION	FINAL PROTECTIVE FINISH		APPROVED <i>[Signature]</i>		CODE IDENT NO. DWG SIZE	
RH	APPLY PART NO PER MIL-STD-130 AS SPECIFIED					00000 C 7790232	
						SCALE 2/1 UNIT WT .033 LB SHEET 1 OF 1	

PART NO. 7790232

PROTECTOR, MUZZLE

00000 C 7790232

SCALE 2/1 UNIT WT .033 LB SHEET 1 OF 1

PDC

00 FORM 1 APR 54 1181

NOTICE: When Government drawings, specifications, or other data are used for any purpose other than in connection with a definitely related Government procurement transaction, the United States Government assumes no responsibility for any inaccuracies, omissions, or errors, and the fact that the Government may have furnished, in any way, any such data, does not constitute an acknowledgment of any right or privilege in or to any patent or invention which may be claimed by any person or corporation.

PHYSICAL PROPERTIES	DO NOT -DE-	APPLY PART NO. -AS-SPECIFIED-	REVISIONS		
			SYM	DESCRIPTION	DATE
YP			A2	SEE EO NO. SA 26856	28MAY63
TS			B2	SEE EO SA 27542	17NOV64
EL2			C	(1) SEE EO SA 29262	18MAY66
RA			D	SEE EO 82048	11 MAR 68
BH	F 7267000	RIFLE, M14	E	(1) SEE EO HRD 92078-2	25JUN63
RH	J9386974	RIFLE, M14NM	F	SEE EO HRD 02138	71FEB 25
			G	(2) SEE ERR HQR 40681	10FEB 75
			H	NOR W8S2022/79-03-26	79-04-01
			J	NORW4S2051/A40824 ECPW5S2069 /S51223	860121

## NOTES:

1. SAME AS MS51976-16,  $\Delta$  ALTER AS SHOWN.
2.  $\Delta$  POINT LENGTH: .070 +.010.
3.  $\Delta$  FINISH NO. 5.3.1.2. OR 5.3.2.2 OF MIL-STD-171.
4. MIL-W-13855 SHALL APPLY.

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

## ALTERED ITEM DRAWING

ORIGINAL FSCM NO. 19205

USED WITH  
SUPPRESSOR, FLASH

~~CODE IDENT NO. 19204~~

PART NO. 7790300

UNLESS OTHERWISE SPECIFIED	ORIGINAL DATE OF DRAWING
DIMENSIONS ARE IN INCHES TOLERANCES ON FRACTIONS DECIMALS ANGLES	10 JUL 58
DRAFTSMAN	CHECKER
TRACER	CHECKER
ENGR	ENGR
SUBMITTED	
HEAT TREATMENT	
FINAL PROTECTIVE FINISH SEE NOTE 3	APPROVED BY ORDER OF THE CHIEF OF ORDNANCE # J. Lynch

SCREW, SET,  
SOCKET

DEPT OF THE ARMY  
ARMS AND AMMUNITION  
ARMS AND AMMUNITION  
ARMS AND AMMUNITION  
ARMS AND AMMUNITION

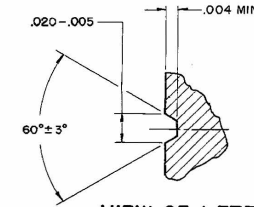
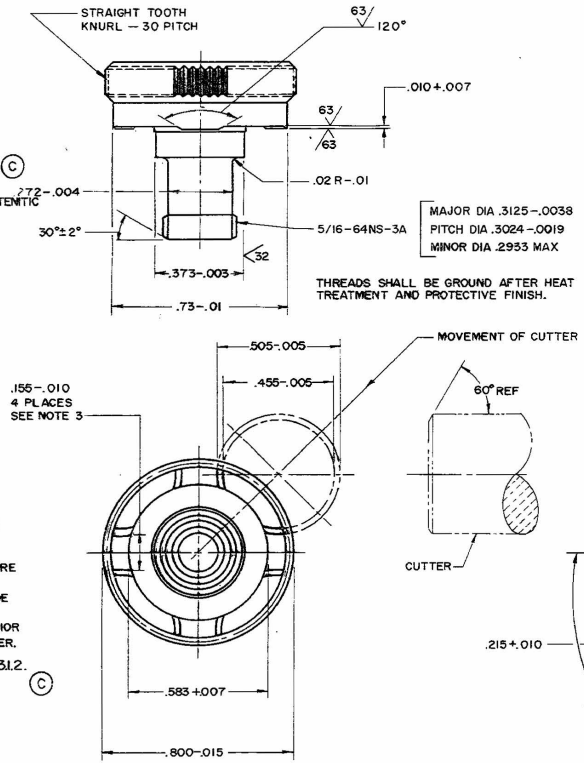
SCALE \_\_\_\_\_  
UNIT WT \_\_\_\_\_

DWG  
SIZE  
A

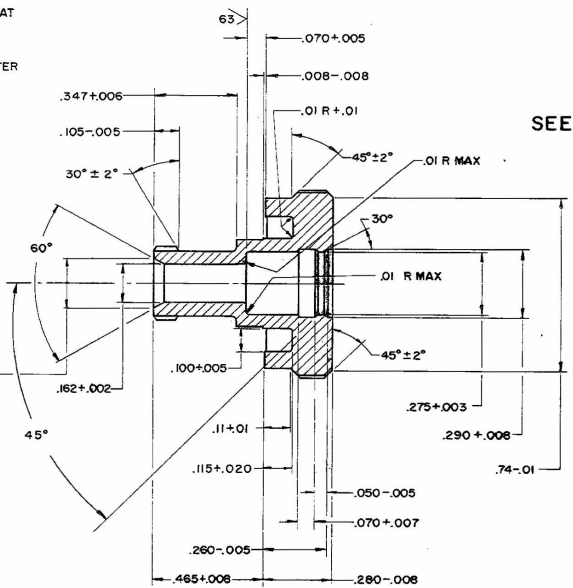
7790300  
SHEET 1 OF 1

NOTES:

1. FINISH 125/ EXCEPT AS NOTED.
2. ALL EDGES AND CORNERS SHALL BE BROKEN .005 R MAX. AND FREE OF BURRS, UNLESS OTHERWISE SPECIFIED.
3. IT IS PERMISSIBLE TO HAVE THIS DIMENSION .155-.025 ON ANY TWO OF THE WIDTHS.
4. MATERIAL: STEEL, CPM15022 ASTM A108 OR QQ-S-651, CPM15022 SPEC QQ-S-657, AUSTENITIC GRAIN SIZE 5 OR FINER
5. HEAT TREATMENT: CARBURIZE AT 1550° TO 1600° F. FROM .008 TO .010 DEPTH, OIL QUENCH, TEMPER 20 MINUTES AT 350° F.
6. HARDNESS: FILE HARD OR SUPERFICIAL ROCKWELL 15 N 90 MINIMUM ON A PROPERLY PREPARED SURFACE.
7. CASE DEPTH SHALL BE MEASURED ON TEST PIECES HEAT TREATED AT THE SAME TIME AND SHALL BE MEASURED BY THE DEPTH OF THE FRACTURED CASE. CORE HARDNESS SHALL BE ROCKWELL A61-73 TAKEN ON THE TEST PIECES USED FOR CASE DEPTH MEASUREMENT AFTER GRINDING OFF A MINIMUM OF .010 TO REMOVE ALL OF THE CASE.
8. HEAT TREATMENT METHOD (SEE NOTES) IS FOR GUIDANCE EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED. THE USE OF STRAIGHT CYANIDE BATH OR CARBO-NITRIDING PROCESS SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF THE CONTRACTING OFFICER.
9. FINAL PROTECTIVE FINISH: FINISH 5.3.12. OF MIL-STD-171.
10. MIL-W-13855 SHALL APPLY.

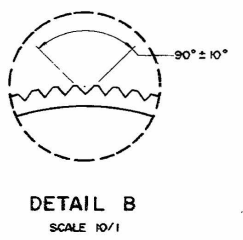
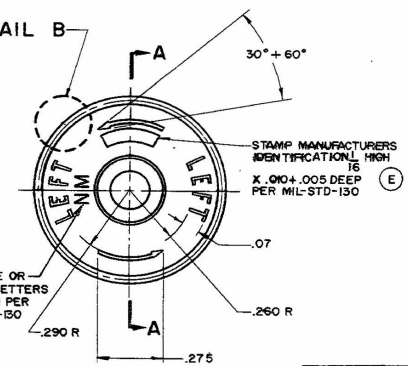


VIEW OF LETTERS AND ARROWS  
SCALE 50/1



SECTION A-A

SEE DETAIL B



CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

ORIGINAL FSCM NO. 19205

CODE IDENT NO. 19204  
PART NO. 7790358

REV	DESCRIPTION	DATE	APPROVAL
1	INITIAL DESIGN	11/11/56	
2	REVISION		
3	REVISION		
4	REVISION		
5	REVISION		
6	REVISION		
7	REVISION		
8	REVISION		
9	REVISION		
10	REVISION		

PHYSICAL PROPERTIES	TOLERANCES ON DIMENSIONS	HEAT TREATMENT	FINAL PROTECTIVE FINISH
1. MATERIAL: CPM15022	1. DIMENSIONS: SEE NOTE 4	1. HEAT TREATMENT: SEE NOTE 5 & 6	1. FINAL PROTECTIVE FINISH: SEE NOTE 9
2. HEAT TREATMENT: SEE NOTE 5	2. MATERIAL: SEE NOTE 4	2. HEAT TREATMENT: SEE NOTE 5 & 6	2. FINAL PROTECTIVE FINISH: SEE NOTE 9
3. HEAT TREATMENT: SEE NOTE 5	3. MATERIAL: SEE NOTE 4	3. HEAT TREATMENT: SEE NOTE 5 & 6	3. FINAL PROTECTIVE FINISH: SEE NOTE 9
4. HEAT TREATMENT: SEE NOTE 5	4. MATERIAL: SEE NOTE 4	4. HEAT TREATMENT: SEE NOTE 5 & 6	4. FINAL PROTECTIVE FINISH: SEE NOTE 9
5. HEAT TREATMENT: SEE NOTE 5	5. MATERIAL: SEE NOTE 4	5. HEAT TREATMENT: SEE NOTE 5 & 6	5. FINAL PROTECTIVE FINISH: SEE NOTE 9
6. HEAT TREATMENT: SEE NOTE 5	6. MATERIAL: SEE NOTE 4	6. HEAT TREATMENT: SEE NOTE 5 & 6	6. FINAL PROTECTIVE FINISH: SEE NOTE 9
7. HEAT TREATMENT: SEE NOTE 5	7. MATERIAL: SEE NOTE 4	7. HEAT TREATMENT: SEE NOTE 5 & 6	7. FINAL PROTECTIVE FINISH: SEE NOTE 9
8. HEAT TREATMENT: SEE NOTE 5	8. MATERIAL: SEE NOTE 4	8. HEAT TREATMENT: SEE NOTE 5 & 6	8. FINAL PROTECTIVE FINISH: SEE NOTE 9
9. HEAT TREATMENT: SEE NOTE 5	9. MATERIAL: SEE NOTE 4	9. HEAT TREATMENT: SEE NOTE 5 & 6	9. FINAL PROTECTIVE FINISH: SEE NOTE 9
10. HEAT TREATMENT: SEE NOTE 5	10. MATERIAL: SEE NOTE 4	10. HEAT TREATMENT: SEE NOTE 5 & 6	10. FINAL PROTECTIVE FINISH: SEE NOTE 9

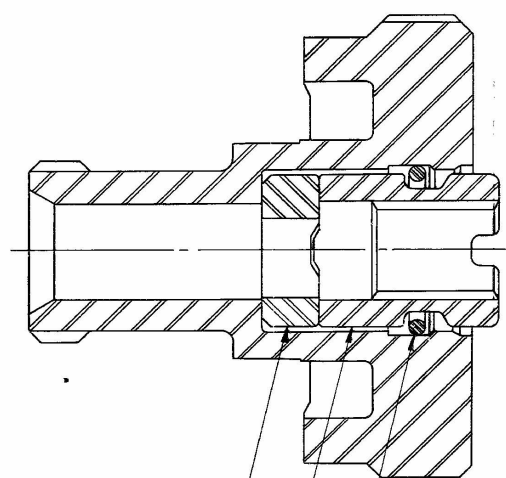
KNOB, WINDAGE, REAR SIGHT

07790358

7790358

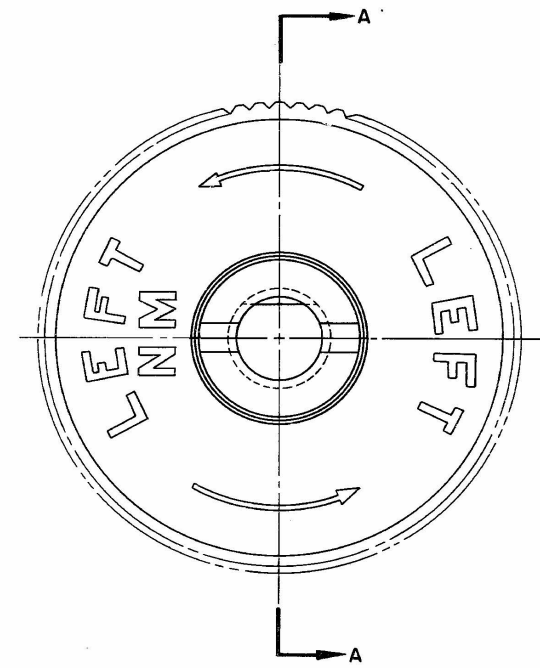
1. WHEN GOVERNMENT DRAWINGS, SPECIFICATIONS, OR OTHER DATA ARE USED IN CONNECTION WITH A DEFENSE ACTIVITY, THE USER SHALL BE RESPONSIBLE FOR OBTAINING THE NECESSARY PERMISSIONS FROM THE GOVERNMENT FOR THE REPRODUCTION AND USE OF SUCH DATA. THE USER SHALL BE RESPONSIBLE FOR OBTAINING THE NECESSARY PERMISSIONS FROM THE GOVERNMENT FOR THE REPRODUCTION AND USE OF SUCH DATA. THE USER SHALL BE RESPONSIBLE FOR OBTAINING THE NECESSARY PERMISSIONS FROM THE GOVERNMENT FOR THE REPRODUCTION AND USE OF SUCH DATA.

- NOTES:
1. LOCATION OF MANUFACTURER'S IDENTIFICATION MARK FOR THIS ASSEMBLY SHOWN ON KNOB
  2. WHEN ASSEMBLED TO RIFLE, THIS ASSEMBLY SHALL READILY ENGAGE THE PINION BY USE OF A SCREWDRIVER AND THE FINGERS ONLY. THE KNOB SHALL ENGAGE AND OPERATE THE REAR SIGHT BASE THROUGH THE FULL RANGE OF THE NINE GRADUATIONS FOR WINDAGE STAMPED UPON THE REAR OF THE RECEIVER.
  3. WHEN ASSEMBLED TO THE RIFLE, IT SHALL BE POSSIBLE TO TIGHTEN THE NUT ON THE PINION WITH A SCREWDRIVER, SUFFICIENTLY, SO THAT BOTH KNOBS BECOME INOPERATIVE BY USE OF THE FINGERS ONLY. BY BACKING OFF THE NUT ONE OR TWO CLICKS (ONE HALF TURN PER CLICK) BOTH KNOBS SHALL THEN BE OPERATIVE BY USE OF THE FINGERS.
  4. NOTCH IN THE LOCK 7312731 SHALL ENGAGE THE TOOTH ON THE NUT 7312726.
  5. INSERT RING INTO RECESS OF NUT AND PRESS NUT FIRMLY INTO HOLE OF KNOB USING CIRCULAR MOTION.
  6. THE NUT SHALL HAVE FREE MOVEMENT ROTATIONALLY AND ENDWISE TO PERMIT READY DISENGAGEMENT FROM THE NOTCH IN THE LOCK, BUT IT SHALL NOT DISASSEMBLE FROM THE KNOB EXCEPT BY FORCEFUL MEANS.
  7. MIL-W-13855 SHALL APPLY.



KNOB-7790358  
RING-7267059  
SEE NOTE 5  
NUT-7312726  
SEE NOTE 6  
LOCK-7312731  
SEE NOTE 4

SECTION A-A



D7790386

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

ORIGINAL FSCM NO. 19205

F	ECFWS2069 / 851223	85042
E	NOR WSS2025/75-03-05	750302
D	SEE EO 120.02138	INTER
C	SEE EO 120.02078-2	CHARGE
B	REF EO 120.5A 27538	NOV
A	REWORK AND REVISED	NOV
	SEE EO 120.02138	NOV

FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 7790386		PART NO. 7790386	
PHYSICAL PROPERTIES	DESIGNATION	ORIGINAL DATE OF DRAWING	REVISIONS
1. US386974	RIFLE WINDAGE	21 NOV 55	
2. NM-30R-MI	MATERIAL	TRACER	
3. HEAT TREATMENT	HEAT TREATMENT	SUBMITTED	
4. APPLICATION	APPLICATION	APPROVED	
5. DO NOT APPLY PART NO.	FINAL PROTECTIVE FINISH	DATE	

KNOB, WINDAGE, REAR SIGHT, ASSEMBLY

7790386

DEPT. OF THE ARMY

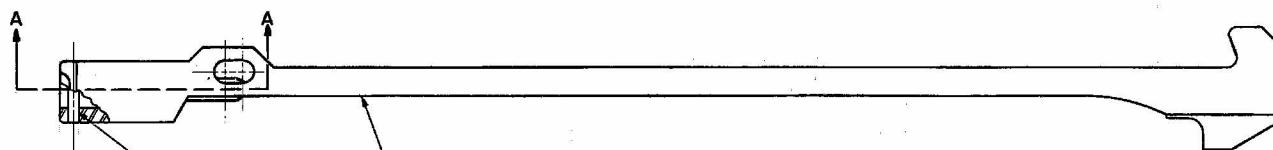
U.S. ARMY WEAPONS COMMAND

7790386

NOTE:

MIL-W-13855 SHALL APPLY. (E)

(C1)



CONNECTOR-7790425

PIN-MS16562-107 OR MS51923-272

PLUNGER-7790426

SPRING-7790427

SECTION A-A

ORIGINAL FSCM NO. 19205

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

CODE IDENT NO. 19204 (C2)

PART NO. 7790424

H	ECPW5S2069R1/861223	860121	SAF 2.0
G	NORW4S2051/840824	179040	SAF 2.0
F	(1) SEE ERM HQR 40681	40 FEB 75	SAF 2.0
E	SEE EO HRD 02138	21 FEB 82	SAF 2.0
D	(1) SEE EO HRD 02078-2	25 JUN 82	SAF 2.0
C	(1-2) SEE EO 82048	17 MAR 83	SAF 2.0
B	SEE EO SA 29261	18 MAY 83	SAF 2.0
A	SEE EO SA 26634	12 AUG 83	SAF 2.0
REV	DESCRIPTION	DATE	APPROVAL

FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 7790424

PHYSICAL PROPERTIES	Q9386974	RIFLE M14NM
TS		
EL 2	F7267000	RIFLE M14
RA		
SH		
NI		
DO NOT	APPLY PART NO.	FINAL PROTECTIVE FINISH
DO	UNDESIGNATED	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	ORIGINAL DATE OF DRAWING
TOLEANCES ON DECIMALS	1 APR 59 +
ANGLES FRACTIONS	DRAFTSMAN J. J. J.
MATERIAL	CHECKER J. J. J.
HEAT TREATMENT	TRACER "X" M. S.
FINAL PROTECTIVE FINISH	ENGINEER R. S. Henry
	SUBMITTED
	R. S. Henry
	ORD CORPS
	APPROVED BY ORDER OF THE
	CHIEF OF STAFF
	ORD CORPS

CONNECTOR ASSEMBLY

DEPT OF THE ARMY  
ROCK ISLAND ARSENAL  
ROCK ISLAND, ILL 61204

DWC  
SIZE  
C  
7790424  
SHEET 1 of 1

SCALE 2/1 UNIT WT

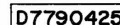
C7790424

B

A

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100
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2. FINISHES  $\geq 5$  EXCEPT AS NOTED. (D)
3. ALL EDGES SHALL BE BROKEN .005  $\pm$  .025 UNLESS OTHERWISE SPECIFIED. (A)
3. HEAT TREATMENT: HEAT TO 1525 $\pm$  150 $\circ$  F. OIL QUENCH. TEMPER 45 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPER TIME SHALL NOT BE REDUCED BELOW T<sub>1</sub> SPECIFIED.
4. ALL EXTERIOR EDGES AND CORNERS IN AREA [A-A] SHALL BE BROKEN .015  $\pm$  0.
5. FINAL PROTOTYPE FINISH: FINISH 53.12 OR 53.2.2 OF MIL-STD-171
6. MIL-W-13895 SHALL APPLY.



CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

PART NO. 7790425

ALTERNATIVE DESIGN (A)

## CONNECTOR

DEPT OF THE ARMY  
ROCK ISLAND ARSENAL  
ROCK ISLAND, ILL 61201  
OWN SIZE  
D 7790425

[illegible]

SCALE	2/1	UNIT WT
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D	PAGE NO.	
	PAGE	OF

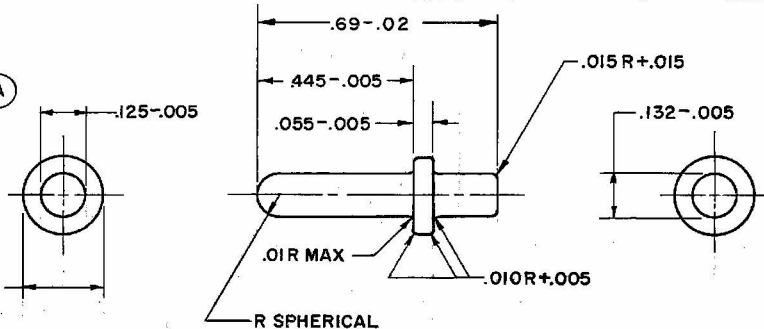


Ⓕ

- D2

4. MIL-W-13855 SHALL APPLY.

E



CURRENT DESIGN ACTIVITY FSCM NO 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

~~CODE IDENT NO.~~ 19204

PART NO. **7790426**

ORIGINAL FSCM NO. 19205

		PHYSICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED		ORIGINAL DATE OF DRAWING   APR 59-4		<b>PLUNGER, CONNECTOR</b>		DEPT OF THE ARMY	
C 8448493		RIFLE,M14NM		DIMENSIONS ARE IN INCHES TOLERANCES ON FRACTIONS DECIMALS ANGLES		DRAFTSMAN <i>W.H. Chester</i> CHECKED <i>W.H. Chester</i>				ROCK ISLAND	
		TS				TRACER <i>W.H. Chester</i> CHECKED <i>W.H. Chester</i>				<del>ARSENAL</del>	
C 7790424		RIFLE,M14		MATERIAL, ASTM A304, A322 STEEL, & A331.		DRAWN <i>W.H. Chester</i> DATE <i>1 APR 59</i>				ROCK ISLAND, ILL 62201	
		RA				SUBMITTED					
		BH		HEAT TREATMENT		<i>R.A. Henry</i> ORD CORPS				DWG SIZE	
NEXT ASSY		USED ON		SEE NOTE 2		APPROVED BY ORDER OF THE				7790426	
APPLICATION		A73-76		FINAL PROCESSING FINISH		<i>W.H. Chester</i> ORD CORPS		SCALE 4/1		UNIT WT	
DO NOT 90°		APPLY PART NO. AS SPECIFIED		SEE NOTE 3						B SHEET OF	

**PLUNGER ,  
CONNECTOR**

~~DEPT OF THE ARMY~~  
~~ROCK ISLAND~~  
~~ARSENAL~~  
~~ROCK ISLAND, ILL 61201~~

DWG SIZE	7790426
-------------	---------

**B** SHEET OF

NOTICE - WHEN GOVERNMENT DRAWINGS, SPECIFICATIONS OR OTHER DATA ARE USED FOR ANY PURPOSE OTHER THAN IN CONNECTION WITH A DEFINITELY RELATED GOVERNMENT PROCUREMENT OPERATION, THE UNITED STATES GOVERNMENT THEREBY INCURS NO RESPONSIBILITY FOR ANY OBLIGATION WHATSOEVER, AND THE FACT THAT THE GOVERNMENT MAY HAVE FORMULATED, FURNISHED OR IN ANY WAY SUPPLIED THE SAID DRAWINGS, SPECIFICATIONS OR OTHER DATA IS NOT TO BE REGARDED BY IMPLICATION OR OTHERWISE AS IN ANY MANNER LICENSING THE HOLDER OR ANY OTHER PERSON OR CORPORATION OR CONVEYING ANY RIGHTS OR PERMISSION TO MANUFACTURE, USE, OR SELL ANY PATENTED INVENTION THAT MAY IN ANY WAY BE RELATED THERETO.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
A		11 OCT 63	
B	REDRAWN & REVISED SEE EO SA 27441	2 NOV 64	<i>[Signature]</i>
C	(1) SEE EO SA 29262	18 MAY 66	<i>[Signature]</i>
D	(1-2) SEE EO 92048	11 MAR 68	<i>[Signature]</i>
E	(1) SEE EO HRD 92078-2	25 JUN 69	<i>[Signature]</i>
F	SEE EO HRD 02138	17 FEB 75	<i>[Signature]</i>
G	(3) SEE ERR HOR 40681	10 FEB 75	<i>[Signature]</i>
H	NOR W8S2022/79-03-26	79-04-01 SA	<i>[Signature]</i>
J	NORW4S2051/840824 (ECPW5S2069 / 851223)	860121	<i>[Signature]</i>

WIRE DIAMETER ----- .0450 ± .0005  
 COIL DIAMETER ( O.D. ) ----- .230 ± .005  
 FREE LENGTH ----- .61 REF  
 TOTAL COILS ----- 9 REF  
 DIRECTION OF HELIX ----- OPTIONAL  
 LOAD AT COMPRESSED LENGTH OF .558 ----- 7 LB ± 1 LB  
 LOAD AT COMPRESSED LENGTH OF .460 ----- 20 LB ± 3 LB  
 SPRING RATE ----- 133 LB/IN REF  
 SOLID LENGTH ----- .43 MAX  
 TYPE OF ENDS ----- CLOSED ENDS  
 MANUFACTURE IN ACCORDANCE WITH  
 MIL-S-13572, TYPE I, GRADE A.

# NOTES:

1. HOLE DIA INTO WHICH SPRING FITS FREELY .240 MIN.
2. ROD DIA OVER WHICH SPRING SLIDES FREELY .132 MAX.
3. HEAT TREATMENT: STRESS RELIEVE AT 425 °F. TO 445 °F. FOR 30 MIN, AFTER COILING.
4. LOAD REQUIREMENTS SHALL APPLY AFTER SPRING HAS BEEN COMPRESSED TO SOLID LENGTH 3 TIMES.

ORIGINAL FSCM NO.19205

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
 U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
 DOVER, NEW JERSEY 07801

(USED WITH CONNECTOR - 7790425 AND 8448492)

PART NO. 7790427

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 1 APR 59		DEPT OF THE ARMY ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801	
YP	C 8448493	RIFLE, M14	TOLERANCES ON DECIMALS ±	DRAFTSMAN E.P.S.	CHECKER P.R.L.		
TS	C 7790424	RIFLE, M14	FRACTIONS ± ANGLES ±	TRACER	CHECKER WWS	SPRING, HELICAL, COMPRESSION	
EL 2			MATERIAL: STEEL WIRE, SPEC QQ-W-470	ENGINEER	ENGINEER		
RA			HEAT TREATMENT	SUBMITTED		DWG SIZE 19204 B 7790427	
BH			SEE NOTE 3	APPROVED			
RH			FINAL PROTECTIVE FINISH LUB OIL, SPEC VV-L-800	SCALE		UNIT WT	SHEET 1 OF 1

00 FORM 1 APR 54 1181

NOTICE - When Government drawings, specifications, or other data are used for any purpose other than in connection with a definitely related Government procurement operation, the United States Government thereby incurs no responsibility, nor any obligation whatsoever; and the fact that the Government may have furnished, furnished, or in any way supplied the said drawings, specifications or other data is not to be regarded by implication or otherwise as in any manner licensing the holder or any other person or corporation, or conveying any rights or permission to manufacture, use, or sell any patented invention that may in any way be related thereto.

PHYSICAL PROPERTIES		DO NOT	APPLY PART NO.	REVISIONS			
		-DO-	-AS SPECIFIED-	SYM	DESCRIPTION	DATE	APPROVAL
YP		APPLICATION					
TS		NEXT ASSY	USED ON	A <sub>1</sub>	SEE EO. SA 25327	2SEP 59	<i>R. Henry</i>
EL2				B <sub>2</sub>	SEE EO SA 25706	26AUG 60	<i>R. Henry</i>
RA				C <sub>2</sub>	REF EO NO. SA 26503	27SEP 62	<i>R. Henry</i>
BH		F7791266	RIFLE, M14	D <sub>1</sub>	SEE EO SA 27473	25JUN 64	<i>R. Henry</i>
PH		F11686427		E	SEE EO SA 28249	16JUL 65	<i>R. Henry</i>
				F	(1-2) SEE EO SA 28757	17DEC 65	<i>R. Henry</i>
				G	SEE EO 82048	11MAR 68	<i>R. Henry</i>
				H	NOR W8S2022/79-03-26	79-04-01	<i>SAC, H-1</i>

(F) (A) (B) (C) (E)

(D)

SEE MILITARY STANDARD I6535, PART NO. MS16535-302, FOR DESCRIPTION OF THIS PART EXCEPT:

SURFACE TREATMENT: NONE

(C)  
(B)

PROTECTIVE FINISH:  
FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.

CODE IDENT NO.

19200

US ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND  
DOVER, NEW JERSEY 07801

(F)

~~CODE IDENT NO. 19204~~

PART NO. 7790473

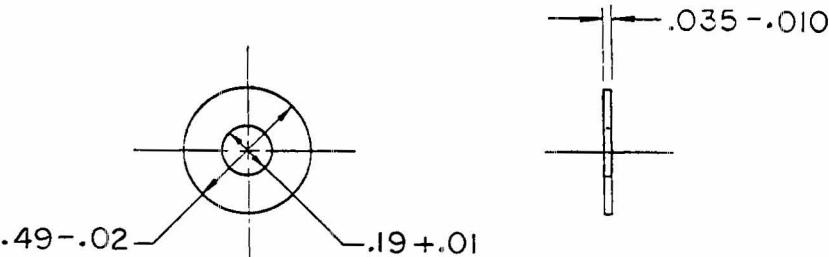
(G)

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON FRACTIONS DECIMALS ANGLES	ORIGINAL DATE OF DRAWING 1 SEP 59		RIVET, TUBULAR, OVAL HEAD	DEPT OF THE ARMY ROCK ISLAND ARSENAL ROCK ISLAND, ILL. 612-02
	DRAFTSMAN <i>EPS</i>	CHECKER <i>W. J.</i>		
	TRACER <i>EPS</i>	CHECKER <i>W. J.</i>		
	ENGR. <i>J. D.</i>	ENGR. <i>R. Henry</i>		
MATERIAL	SUBMITTED <i>W. J. Lusk</i>		SCALE UNIT WT	DWG SIZE A
HEAT TREATMENT	ORD CORPS			
FINAL PROTECTIVE FINISH	APPROVED BY ORDER OF THE CHIEF OF ORDNANCE <i>H. F. Lynch</i> ORD CORPS			
			7790473	
			SHEET 1 OF 1	

NOTES:

- 1-FINISH  $\sqrt{250}$  ALL OVER.
- 2-BREAK ALL EDGES .015 MAX.
- 3-MATERIAL: STEEL, SPEC ASTM A109.
- 4-MIL-W-13855 AND ANSI Y14.5 APPLY.
- 5-FINAL PROTECTIVE FINISH: FINISH NO. 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
M	REDRAWN WITH CHANGE ERR Z9Z1175AG (ECP W2S0056/821116	890913	DECI-CHT EJB



CURRENT DESIGN ACTIVITY CAGE CODE 19200  
U.S. ARMY  
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER  
PICATINNY ARSENAL, NEW JERSEY 07806-5000

PART NO. 7790474

		MECHANICAL PROPERTIES		DO NOT SCALE DRAWING		ORIGINAL DATE OF DRAWING		SPRINGFIELD ARMORY, SPRINGFIELD, MA 01101	
				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		1 SEP 59			
F11010263		RIFLE, M14		YP		DRAFTSMAN		CHECKER	
F11686427				TS		E.P.S.		G.V.S.	
F11010282		RIFLE, M14		EL2		ENGR		ENGR	
		NM		RA		A.C.		R.H.	
		RIFLE, M21		BH		ENGR		ENGR	
NEXT ASSY		USED ON		RH		SUBMITTED		SIZE CODE IDENT NO.	
APPLICATION						V.A. LUNKKMEN		B 19205	
						APPROVED		7790474	
						H. LYNCH		SCALE 2/1 UNIT WT. SHEET 1 OF 1	

(1) NAME OF PERSON (2) ADDRESS (3) CITY (4) STATE (5) ZIP		(6) FULL DISCLOSURE OF OFFENSE (7) NAME OF VICTIM (8) ADDRESS OF VICTIM (9) CITY OF VICTIM (10) STATE OF VICTIM (11) ZIP OF VICTIM (12) DATE OF INCIDENT (13) TIME OF INCIDENT (14) WEAPON USED (15) TYPE OF INCIDENT (16) SUSPECTED (17) OTHER INFORMATION		(18) DATE OF REPORT (19) NAME OF REPORTER (20) ADDRESS OF REPORTER (21) CITY OF REPORTER (22) STATE OF REPORTER (23) ZIP OF REPORTER (24) SIGNATURE OF REPORTER (25) DATE OF SIGNATURE	
(26) NAME OF AGENCY (27) ADDRESS OF AGENCY (28) CITY OF AGENCY (29) STATE OF AGENCY (30) ZIP OF AGENCY (31) SIGNATURE OF AGENCY (32) DATE OF SIGNATURE		(33) NAME OF AGENCY (34) ADDRESS OF AGENCY (35) CITY OF AGENCY (36) STATE OF AGENCY (37) ZIP OF AGENCY (38) SIGNATURE OF AGENCY (39) DATE OF SIGNATURE		(40) NAME OF AGENCY (41) ADDRESS OF AGENCY (42) CITY OF AGENCY (43) STATE OF AGENCY (44) ZIP OF AGENCY (45) SIGNATURE OF AGENCY (46) DATE OF SIGNATURE	

1. CHEMICALS AND SOURCES OF SUPPLY.  
EPON RESIN NO.820—SHELL CHEMICAL CORP., N.Y., N.Y.  
VERSAMID POLYAMIDE RESIN NO.140—CHEMICAL DIV OF GENERAL MILLS, KANKAKEE, ILL.  
DIETHYLENETRIAMINE (TECH GRADE)—MATHESON COLEMAN & BELL, EAST RUTHERFORD, N.J.  
MILLED FIBERGLASS (1/32" LENGTH)—FIBERGLASS DIV OF FERRO CORP, NASHVILLE, TENN.  
SUBSTITUTE MATERIALS SHALL NOT BE USED WITHOUT APPROVAL BY SPRINGFIELD ARMOY.

EPON RESIN NO. 820	75 PARTS
VERSAMID NO. 140	25 PARTS
DIETHYLENETRIAMINE	6 PARTS
MILLED FIBERGLASS	27 PARTS

NOTE: THE ABOVE FORMULATION AFTER MIXING WILL GIVE A SERVICEABLE POT LIFE UP TO 90 MINUTES OR LONGER AT AMBIENT TEMPERATURES PROVIDED THE MIXTURE IS SPREAD THINLY ON A FLAT HARD SURFACE (THIS WILL REDUCE EXOTHERM WHICH SHORTENS POT LIFE).

3. STOCKS SHALL BE ALLOWED TO DRY AFTER FINAL PROTECTIVE FINISH (CHINAWOOD OIL) FOR A MINIMUM 7 DAY PERIOD PRIOR TO APPLYING GLASS BEDDING MATERIAL.

4. THE STOCK ASSEMBLY AND FIRING MECHANISM OF EACH WEAPON SHALL BE IDENTIFIED BY MARKING OR STAMPING IN A SUITABLE INTERIOR SURFACE WITH THE LAST 4 DIGITS OF THE SERIAL NUMBER OF MATING RECEIVER (BARREL AND RECEIVER ASSEMBLY). THESE ASSEMBLIES SHALL NOT BE INTERCHANGED AFTER COMPLETION OF GLASS BEDDING.

5. ALL METALLIC COMPONENTS AND/OR ASSEMBLIES WITHIN AREA -A-  
COMING IN CONTACT WITH GLASS BEDDING MATERIAL SHALL BE DEGREASED.

6. ALL METALLIC AREAS OF RIFLE ACTION ASSEMBLY WITHIN AREA -A- SHALL BE PROTECTED FROM BONDING BY GLASS BEDDING MATERIAL BY APPLYING, EITHER BY BRUSHING OR DIPPING, TWO COATS OF MOLD RELEASE COMPOUND. SOURCE OF SUPPLY:

RAM CHEMICALS, INCORPORATED; 210 EAST ALONDRA BOULEVARD  
GARDENA, CALIFORNIA — GARA NO.225  
A SUBSTITUTE MATERIAL SHALL NOT BE USED WITHOUT APPROVAL BY  
SPRINGFIELD ARMOY.

7. FILL THE ROUTED AREAS OF STOCK WITH GLASS BEDDING MATERIAL TO INSURE THAT THE IMBEDDED AREAS ARE COMPLETELY COVERED PROVIDING EXCESS MATERIAL TO INSURE COMPLETE SURFACE BEDDING.

ASSEMBLE, BED AND BOND LINER ASSEMBLY, STOCK AND SCREWS, STOCK LINER TO STOCK WITH GLASS BEDDING MATERIAL (DO NOT APPLY MOLD RELEASE COMPOUND TO LINER AND SCREWS) ALLOWING FOR FINAL TIGHTENING OF SCREWS AFTER COMPLETE RIFLE ACTION HAS BEEN ADJUSTED.

IMMEDIATELY FOLLOWING THE ABOVE PROCEDURE, THE RIFLE ACTION (BARREL AND RECEIVER ASSEMBLY AND FIRING MECHANISM) SHALL BE BEDDED TO THE STOCK AND THE RECEIVER LEGS ALIGNED WITH STOCK LINER RECOIL SURFACES (SEE ZONE 3A, SHEET 1). ADJUST THE TRIGGER GUARD (FIRING MECHANISM) TO OBTAIN THE REQUIRED TENSION (SEE ZONE 4B).

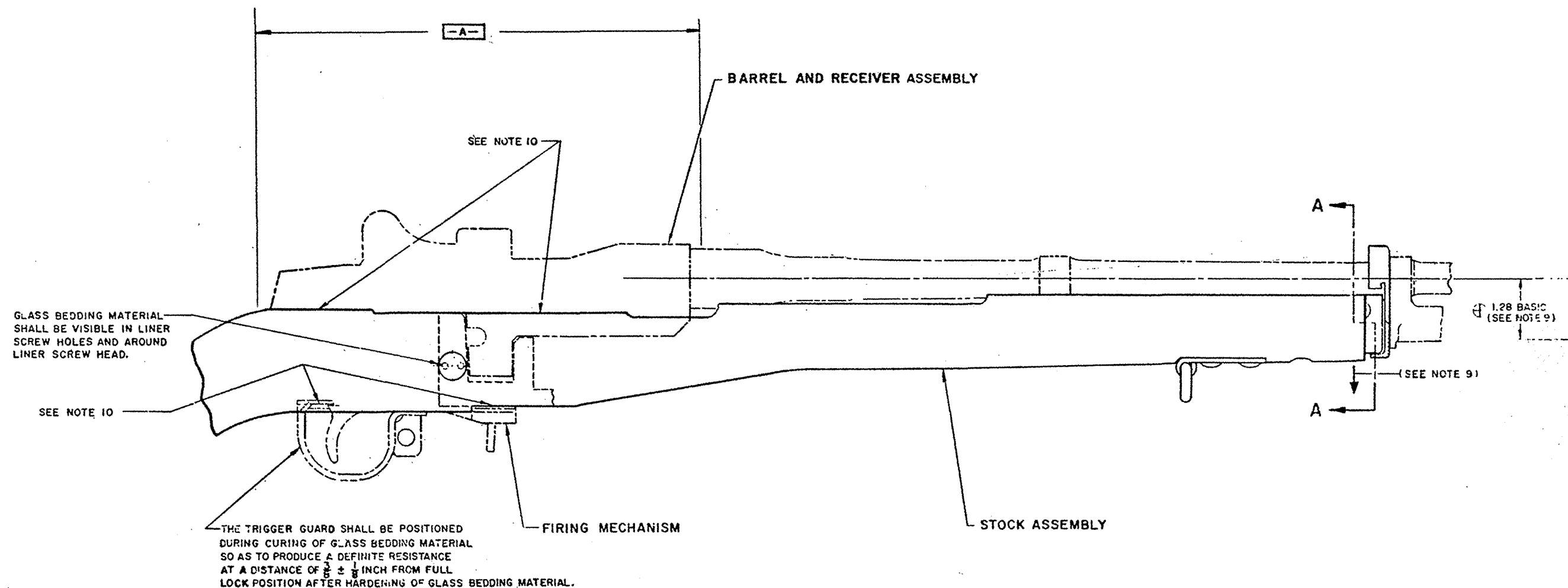
ALLOW THE BEDDED RIFLE ACTION TO DRY A MINIMUM OF 8 HOURS.

8. ON COMPLETION OF GLASS BEDDING ALL EXCESS MATERIAL IN SOFT STATE AROUND PERIPHERY OF MATING COMPONENTS OR ASSEMBLIES SHALL BE REMOVED. NO REMOVAL OF GLASS BEDDING MATERIAL IS PERMITTED (AFTER IT SOLIDIFIES) CONTAINING THE MOLDED IMPRESSIONS OF THE RECEIVER AND TRIGGER HOUSING (FIRING MECHANISM) BEDDING SURFACES.

9. ASSEMBLIES SHALL BE ADJUSTED SO THAT THE STOCK EXERTS A 1 TO 15 LB MAX LOAD ON BAND IN DIRECTION SHOWN AFTER HARDENING OF GLASS BEDDING MATERIAL.

K. 0.15 MAXIMUM BUILDUP OF GLASS BEDDING MATERIAL PERMISSIBLE ON UPPER AND LOWER BEDDING SURFACES OF STOCK.

11. QUALIFICATION OF  $\oplus$ ,  $\odot$  REQUIREMENTS SHALL BE MAINTAINED DURING CURING OF GLASS BEDDING MATERIAL WITH BARREL AND RECEIVER ASSEMBLY, STOCK ASSEMBLY AND FIRING MECHANISM AS SHOWN.



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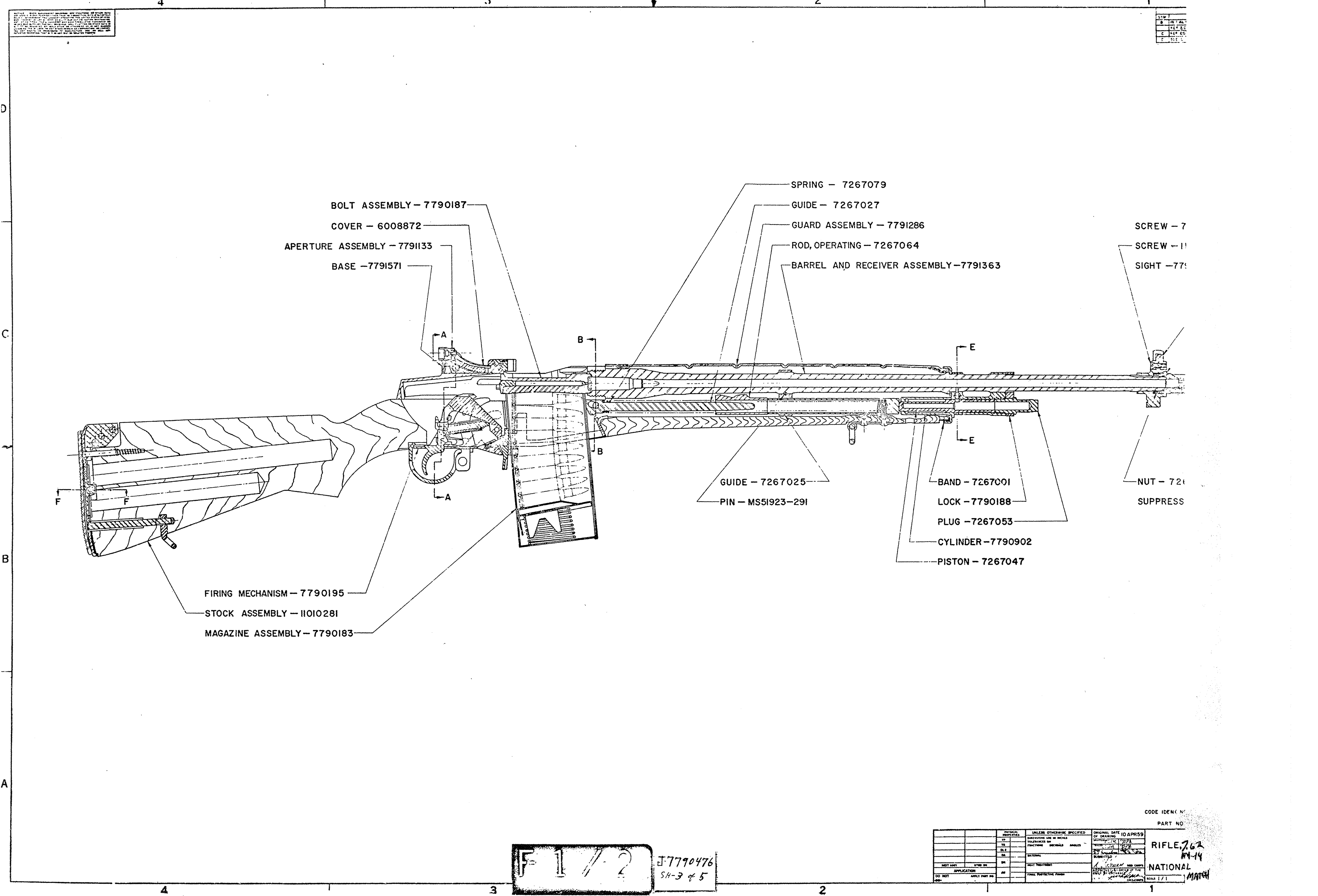
RIFLE, 762

84-15

**NATIONAL**

## T MATCH





REVISED	DATE
1	10/1/59
2	10/1/59
3	10/1/59
4	10/1/59

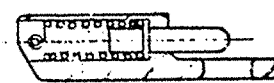
CODE IDENTIFICATION  
PART NO.

F-1 / 2  
7790476  
SH-3 & 5

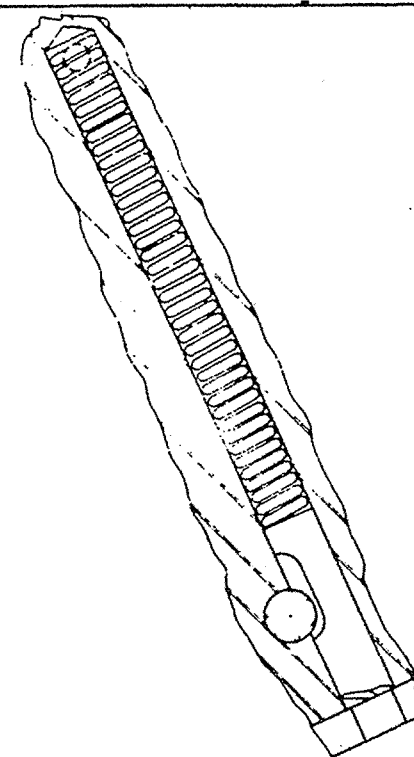
PHYSICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED		ORIGINAL DATE 10 APR 59	
SP	1	DIMENSIONS ARE IN INCHES	1/16	DATE	10/1/59
TS	1	TOLERANCES ON DIMENSIONS	0.005	BY	10/1/59
DL	1	FINISHES	0.005	CHKD	10/1/59
DR	1	MATERIAL	0.005	SUBMITTED	10/1/59
DR	1	HEAT TREATMENT	0.005	APPROVED	10/1/59
DR	1	FINAL INSPECTION	0.005	SCALE	1/1

RIFLE 762  
M-14  
NATIONAL MATCH

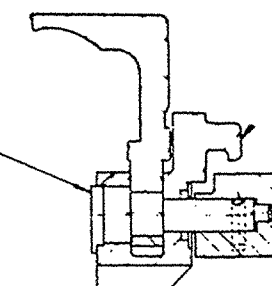




PARTIAL SECTION OF CONNECTOR ASSEMBLY



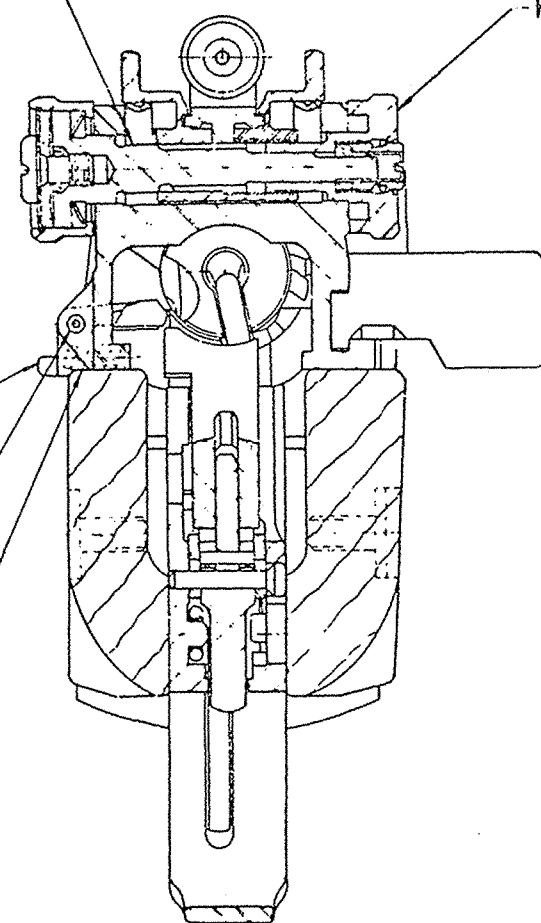
PARTIAL SECTION D-D



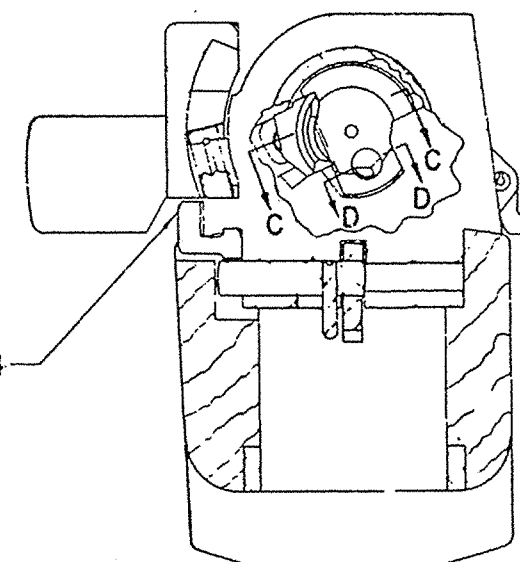
RELEASE - 7790192

— LOCK - 7267172

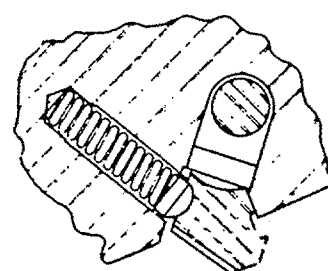
PARTIAL SECTION SHOWING PARTS ASSEMBLED AND WELDED  
FOR SEMIAUTOMATIC FIRE ONLY. REF DWG F7791363



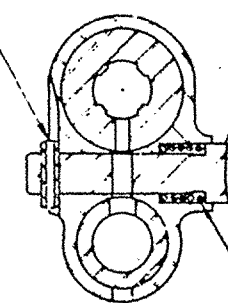
SECTION A-A



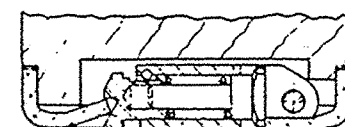
SECTION B-B



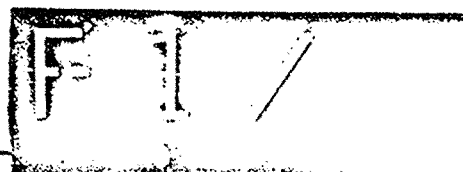
PARTIAL SECTION C-C



SECTION E-E



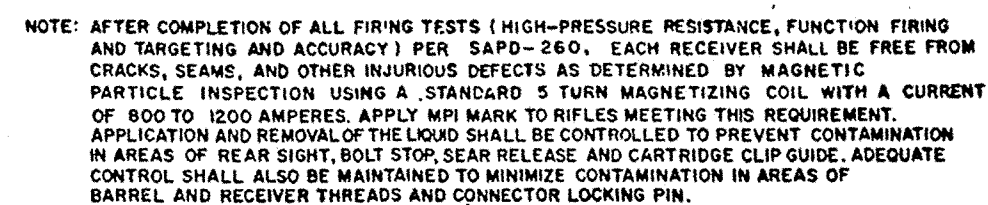
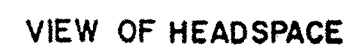
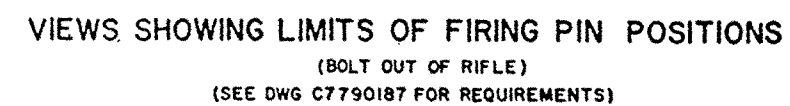
PARTIAL SECTION F-F



J-7790476  
SH-4 of 5

[illegible]

RIFLE, 7.62  
MM  
NATIONAL  
SCALE 2/1

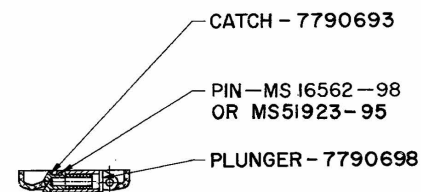


FIRING PIN INDENT SHALL BE TAKEN IN SOFT, ANNEALED, 99.90% PURE COPPER COMPRESSION CYLINDERS (GOVERNMENT STANDARD) AND SHALL NOT BE OFF CENTER MORE THAN ONE - HALF THE DIAMETER OF THE FIRING PIN POINT.

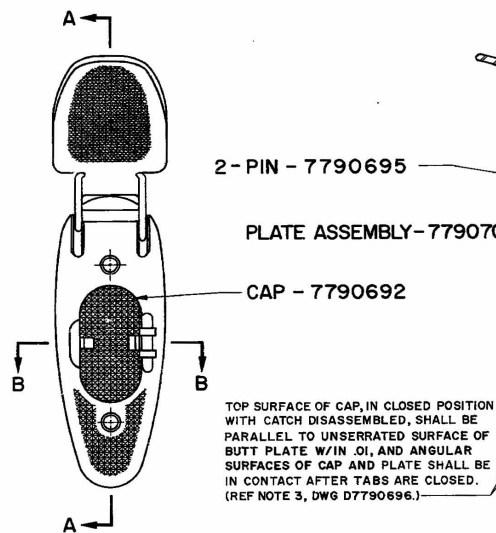


PHYSICAL PROPERTIES		UNLITE OTHERWISE SPECIFIED		ORIGINAL DATE OF DRAINING TO 10/15/56		RIFLE, 7.62 M 14 NATIONAL MATCH
TYPE	WEIGHTS ARE IN OUNCES	TOLERANCES ON FINISHES	REMARKS	DATE	REMARKS	
ST. 1						
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ST. 6						
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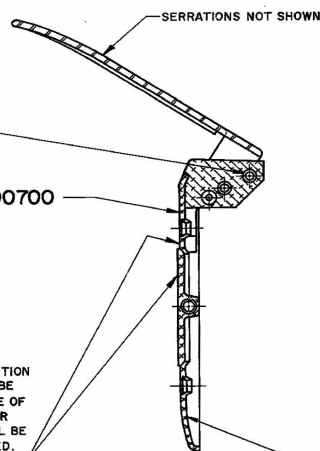
NOTES:  
I. MIL-W-13855 APPLIES.



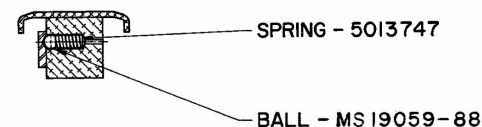
SECTION B-B



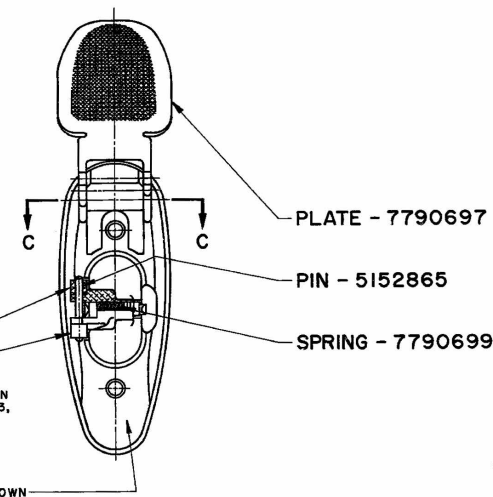
TOP SURFACE OF CAP, IN CLOSED POSITION WITH CATCH DISASSEMBLED, SHALL BE PARALLEL TO UNSERRATED SURFACE OF BUTT PLATE W/IN .01, AND ANGULAR SURFACES OF CAP AND PLATE SHALL BE IN CONTACT AFTER TABS ARE CLOSED. (REF NOTE 3, DWG D7790696.)



SECTION A-A



SECTION C-C



CLOSE TABS TIGHT ON PIN 5152865. (REF SEE NOTE 3, DWG D7790696.)

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

ORIGINAL FSCM NO. 19205

CODE IDENT NO. 19204 (K)

FOR LIST OF PARTS SEE ENGINEERING PARTS LIST 7790686

PART NO. 7790686

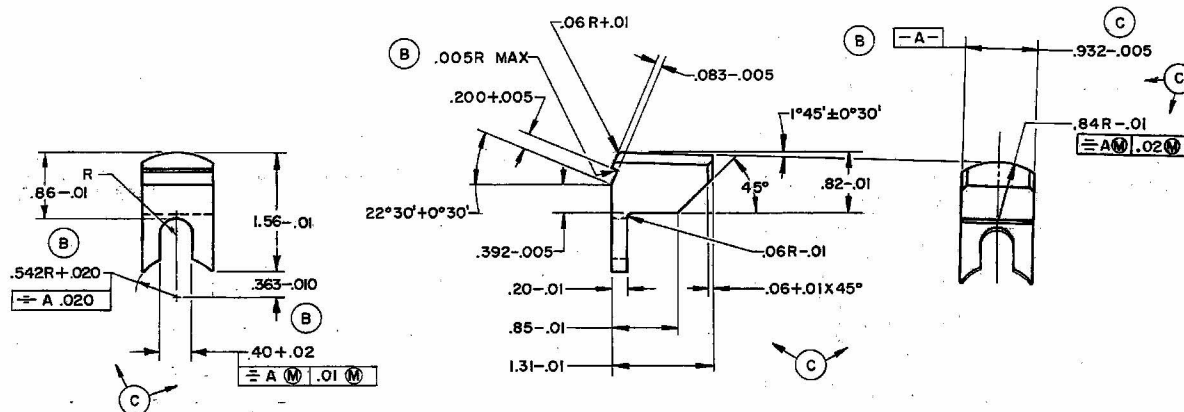
PHYSICAL PROPERTIES		9392337 RIFLE, M14-NM		TOLERANCES ON DECIMALS		ORIGINAL DATE OF DRAWING 1 SEP 59	
9392337 RIFLE, M14		F11010264 RIFLE, M14		DIMENSIONS ON FRACTIONS		CHECKED BY 3	
F11686429				MATERIAL		ENGINEER'S CHECK 1/15/60	
				HEAT TREATMENT		ENGINEER'S CHECK 1/15/60	
				FINAL PROTECTIVE FINISH		APPROVED BY ORDER OF THE CHIEF OF RESEARCH	
DO NOT APPLY PART NO.		AD-SPECIFIED				SCALE 1/1 UNIT WT	

PLATE ASSEMBLY, WITH SHOULDER REST		7790686	
D		SHEET 1 OF 1	

M	ECFW552065 / 7851223	785012	1/15/60
N	NORW452051 / 840624		
L	NORW552022 / 79-03-26	79-04-01	1/15/60
K	(2) SEE ERR HQR 40681	10FEB79	
H	SEE EO HRD 02138	11FEB79	
G	(1) SEE EO HRD 92078-2	22JAN79	
F	(1-2) SEE EO 92048	10MAY79	
E	SEE EO SA 29281	10MAY79	
D	SEE EO NO. SA 27473	22JAN79	
C	SEE EO NO. SA 26825	30NOV78	
B	SEE EO NO. SA 26856	28NOV78	
A	REF EO NO. SA 26805	27NOV78	
	REDRAWN AND REVISED	28NOV78	
	SEE EO SA 25797		

## NOTES:

1. FINISH 125/.
2. DIMENSIONS SHOWN ARE FINAL DIMENSIONS AFTER APPLICATION OF FINAL PROTECTIVE FINISH PER ASSEMBLY C7790700. APPROX 50% OF COATING THICKNESS IS PENETRATION INTO BASE METAL AND 50% IS SURFACE BUILD-UP.
3. FOR ALTERNATIVE ASSEMBLY (BRAZING) SEE PLATE ASSEMBLY, BUTT, C7790700
4. ALL EDGES SHALL BE BROKEN .005+ .010 UNLESS OTHERWISE SPECIFIED.
5. MIL-W-13855 SHALL APPLY.



ORIGINAL FSCM NO. 19205

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

CODE IDENT NO. 19204  
PART NO. 7790691

K	ECPW5S2069. /851223 NORW4S2051/840824	86012	SAF
J	NOR W8S2022/79-03-26	790401	SAF
H	SEE EO HRD 02138	71FEB27	SAF
G	(I) SEE EO HRD 92078-2	25JUN68	SAF
F	SEE EO 82048	11MAY68	SAF
E	(I) SEE EO SA 29261	18MAY68	SAF
D	SEE EO SA27502	8JAN 68	SAF
C	SEE EO SA 26825	8NOV68	SAF
B	SEE EO SA 26151	20OCT68	SAF
A	REDRAWN AND REVISED	28SEP68	SAF
	SEE EO SA 25797		SAF
SYN	DESCRIPTION	DATE	APPROVAL
REVISIONS			

PHYSICAL PROPERTIES	APPLICATION	HEAT TREATMENT
SP		
T2		
EL 2	C7790700	RIFLE, M14
RA		
BN	NEXT ASSY	USED ON
BN	DO NOT APPLY PART NO.	AT ASSEMBLY
	46-APPROVED	AT ASSEMBLY

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON	DECIMALS
ANGLES $\pm 1^\circ$	FRACTIONS
MATERIAL	
ALUMINUM, FED. SPEC QQ-A-200/8,	
TEMPER. C.	
HEAT TREATMENT	
AT ASSEMBLY	
FINAL PROTECTIVE FINISH	
AT ASSEMBLY	

ORIGINAL DATE OF DRAWING	1 SEP 59
DRAFTSMAN J. P.	CHECKER J. P.
TRACER J. P.	CHECKER J. P.
ENGINEER J. P.	CHECKER J. P.
SUBMITTED	
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE	
ORD CORPS	

BLOCK, HINGE,  
SHOULDER REST

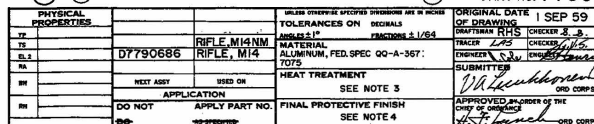
DEPT OF THE ARMY  
US ARMY WEAPONS  
COMMAND  
ROCK ISLAND, ILL. 61201

DWG NO. 7790691  
C

SCALE 1/1 UNIT WT

PDC

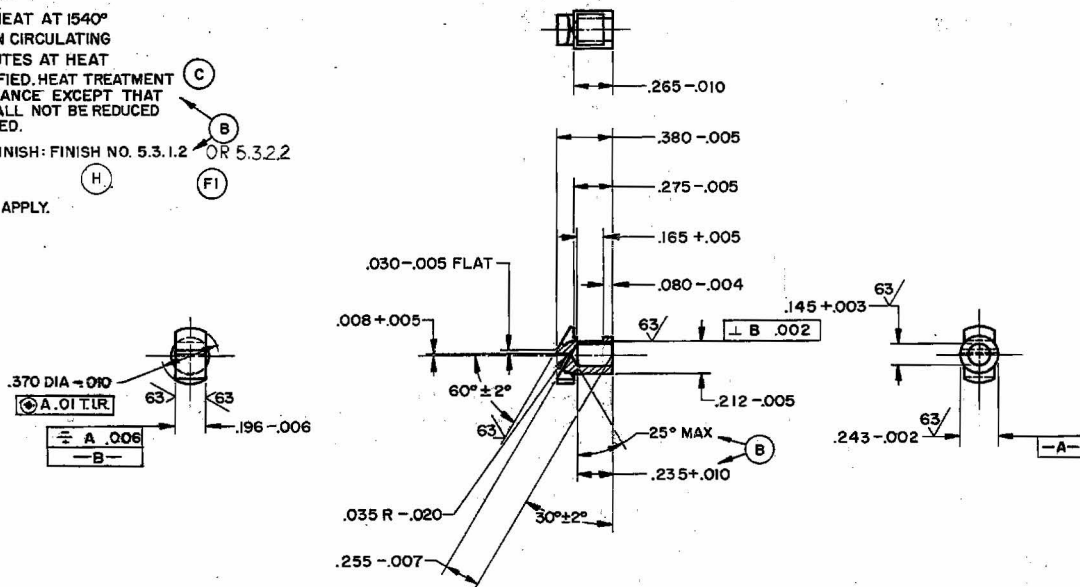
7 MIL-W-13855 SHALL APPLY.



SCALE	2/1	UNIT WT
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NOTES:

1. FINISH 125/ EXCEPT AS NOTED.
2. ALL CORNERS AND EDGES SHALL BE BROKEN .005 +.010 UNLESS OTHERWISE SPECIFIED.
3. HEAT TREATMENT: HEAT AT 1540° TO 1600°F. QUENCH IN CIRCULATING OIL. TEMPER 30 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
4. FINAL PROTECTIVE FINISH: FINISH NO. 5.3.1.2 OF MIL-STD-171, OR 5.3.2.2
5. MIL-W-13855 SHALL APPLY.



CURRENT DESIGN ACTIVITY FSCM NO.19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

CODE IDENT NO. 19204  
PART NO. 7790693

ORIGINAL DESIGN ACTIVITY FSCM NO. 19203

PHYSICAL PROPERTIES	
YP	
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DO NOT	
APPLY PART NO.	
40-SP-00000	

TOLERANCES ON DECIMALS	
ANGLES	FRACTIONS
MATERIAL STEEL, ALLOY 4140, 4145, 8645 OR 8740 ASTM A322 OR ASTM A331	
HEAT TREATMENT	
SEE NOTE 3	
FINAL PROTECTIVE FINISH	
SEE NOTE 4	

ORIGINAL DATE OF DRAWING	1 SEPT 59
DRAWN BY	J. D.
CHECKED BY	J. S.
ENGINEER	J. S.
SUBMITTED	
APPROVED BY	
IN CHARGE OF THE	
OFFICE OF ORDNANCE	
DATE	

CATCH,  
BUTT PLATE

DEPT OF THE ARMY  
ROCK ISLAND ARSENAL  
ROCK ISLAND, ILL 62208

7790693  
C SHEET 1 OF 1

SYM	DESCRIPTION	DATE	APPROVAL
K	ECPW5S2069 / 851223		
J	NOR W4S2051 / 840824	850121	MR
J	NOR W8S2022 / 79-03-26	790401	SA
H	(1) SEE ERR HQR4068	10 FEB 79	
G	SEE EO HRD 02138	11 FEB 79	
F	(1-2) SEE EO HRD 92078-2	25 JUN 68	
E	SEE EO 82048	11 MAR 68	
D	(1) SEE EO SA 29261	18 MAY 66	
C	SEE EO SA 26825	18 NOV 63	
B	SEE E.O. SA 26205	8 JUN 61	
A	REDRAWN AND REVISED	28 SEP 60	
A	SEE EO SA 28797		

C7790693

C7790693

B

M


A

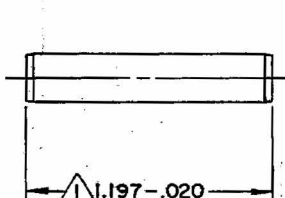
00 FORM 1 APR 54 T181

NOTICE: When Government drawings, specifications, or other data are used for any purpose other than in connection with a specifically stated Government procurement operation, the Government and its agents assume no responsibility and no liability, inasmuch as they have not been authorized to do so by the Government. It is the policy of the Government to protect its rights in its inventions and to prevent the unauthorized use of its inventions in its procurement operations.

PHYSICAL PROPERTIES		DO NOT	APPLY PART NO.	REVISIONS			
		-00-	-AS SPECIFIED-	SYM	DESCRIPTION	DATE	APPROVAL
YP			APPLICATION	A	SEE EO SA 25797	28SEP60	<i>Henry</i>
TS			NEXT ASSY	B <sub>3</sub>	SEE EO SA 26648	11 MAR 63	<i>A. J. De</i>
EL2			USED ON	C	(1) SEE EO SA 29261	18 MAY 66	<i>A. J. De</i>
RA				D	SEE EO 82048	11 MAR 68	<i>R. De</i>
BH			D7790686 RIFLE, M14	E	(1) SEE EO HRD 92078-2	25 JUN 65	<i>R. De</i>
RH			D7790686 RIFLE, M14NM	F	SEE EO HRD 02138	7 FEB 75	<i>A. J. De</i>
				G	(2) SEE ERR HQ 40681	10 FEB 75	<i>A. J. De</i>
				H	NOR W8S2022/79-03-26	790101	<i>A. J. De</i>
				J	NORW452051/840824 ECPW552062/851223	850121	<i>A. J. De</i>

## NOTES:

1. SAME AS MS 51923-419,  ALTER AS SHOWN.
2. MIL-W-13855 SHALL APPLY.



CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

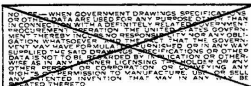
ORIGINAL FSCM NO. 19205   
ALTERED ITEM DRAWING

USED IN PLATE ASSEMBLY  
WITH SHOULDER REST 

CODE IDENT NO. ~~19204~~PART NO. 7790695 

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON FRACTIONS DECIMALS ANGLES	ORIGINAL DATE OF DRAWING	1 SEP 59	PIN, SPRING - TUBULAR, COILED, MEDIUM DUTY	DEPT OF THE ARMY
	DRAFTSMAN CHECKER TRADER ENGINEER SUBMITTED	EPS EPS EPS EPS		ROCK ISLAND ARSENAL ROCK ISLAND, ILL. 61201
MATERIAL	APPROVED BY ORDER OF THE CHIEF OF DIVISION			7790695
HEAT TREATMENT	SCALE - 2/1			SHEET 1 OF 1
FINAL PROTECTIVE FINISH	UNIT WT			

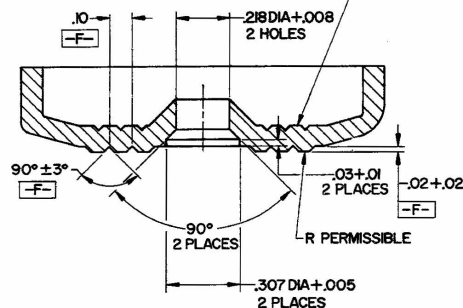




## NOTES:

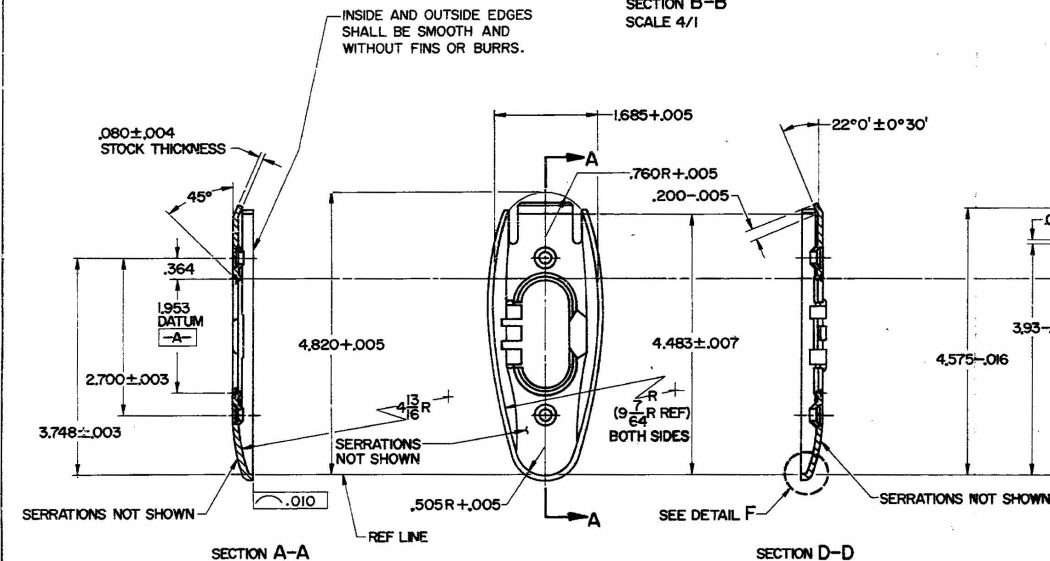
1. FINISH 125/
2. DIMENSIONS SHOWN, EXCEPT STOCK THICKNESS, ARE FINAL DIMENSIONS AFTER APPLICATION OF FINAL PROTECTIVE FINISH PER ASSEMBLY C7790700. APPROX 50% OF COATING THICKNESS IS PENETRATION INTO BASE METAL AND 50% IS SURFACE BUILD-UP.
3. DIMENSIONS  $\boxed{-E-}$  SHALL BE ADJUSTED TO MEET REQUIREMENTS SPECIFIED ON DWG D7790686.
4. FOR ALTERNATIVE ASSY (BRAZING) SEE PLATE ASSY, BUTT, C7790700.
5. ALL EDGES SHALL BE BROKEN .005+ .010 UNLESS OTHERWISE SPECIFIED.
6.  $\boxed{-C-}$  IS ESTABLISHED BY CENTERS OF .218 DIA + .008 HOLES.
7. MIL-W-13855 SHALL APPLY.

DIA PRESSURE SHALL BE SUFFICIENT TO PRODUCE EXTERIOR CONTOUR INDICATED WITHIN LIMITS OF DIMENSIONS  $\boxed{-F-}$



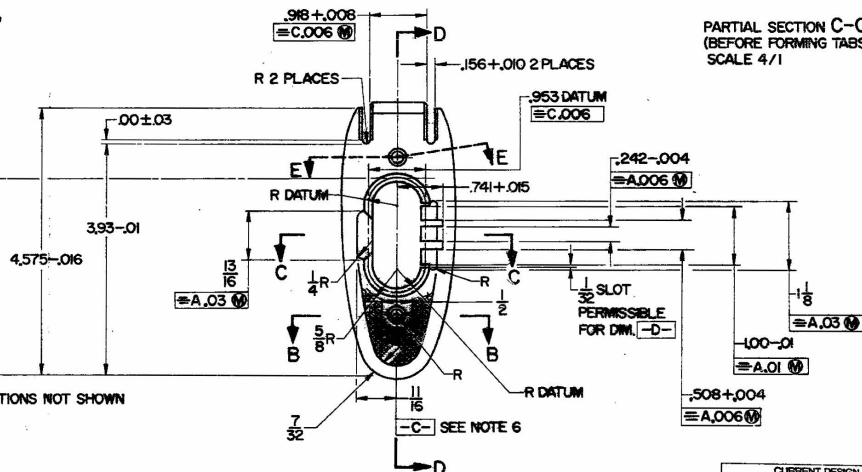
SECTION B-B  
SCALE 4/1

INSIDE AND OUTSIDE EDGES SHALL BE SMOOTH AND WITHOUT FINS OR BURRS.



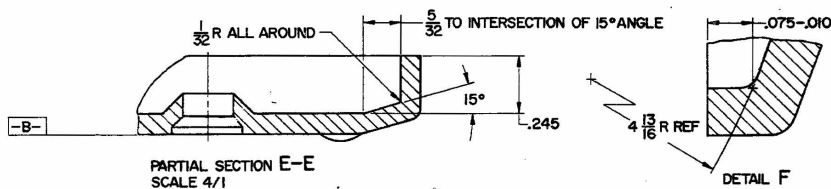
SECTION A-A

SECTION D-D



SECTION C-C  
SCALE 4/1

PARTIAL SECTION C-C  
(BEFORE FORMING TABS)  
SCALE 4/1



PARTIAL SECTION E-E  
SCALE 4/1

DETAIL F  
SCALE 10/1

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
B		20 OCT 61	
C	REDRAWN AND REVISED		
D	SEE EO NO. 3455825	8 NOV 63	
E	SEE EO NO. 3457502	9 JAN 64	
F	SEE EO 62248	11 MAR 66	
G	(1) SEE EO HRO 92076-2	25 JUN 69	
H	SEE EO HRO 02138	71 FEB 75	
I	NORWAS2051/ 84 08 24	79-04-01	
J	ECPW552069 / 8512 23	86 01 21	

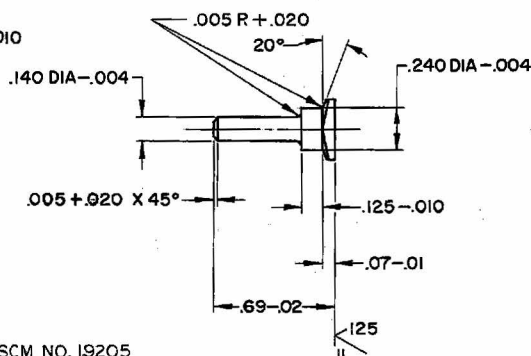
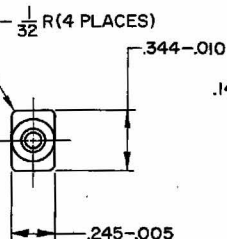
MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 1 SEP 59		PART NO. 7790696 (E1)	
YP		TOLERANCES ON DECIMALS ± .010		DRAFTSMAN	CHECKER	DESIGN OF THE ARMY	
TS		FRACTIONS ± 1/64 ANGLES ± 1°		TRACER	CHECKER	ARMY WEAPONS COMMAND - ROCK ISLAND ARMO	
EL		MATERIAL ALUMINUM, FED SPEC QQ-A-250-1		ENGINEER	ENGINEER	PLATE, BUTT	
RA		HEAT TREATMENT AT ASSY		APPROVED		MODE-IDENTIFYING DWG SIZE 19203 D 7790696	
BH		FINAL PROTECTIVE FINISH AT ASSY				SCALE 1/1 UNIT WT SHEET 1 OF 1	
RH		DO NOT APPLY PART NO				PDC	



86790698

## NOTES:

1. FINISH 125/ EXCEPT AS NOTED.
2. ALL EDGES SHALL BE BROKEN  
.005+.010 UNLESS OTHERWISE  
SPECIFIED.
3. MATERIAL: STEEL,  
ASTM A108:1020,1022 OR  
SPEC QQ-S-637-1117
4. HEAT TREATMENT: CARBURIZE  
AT 1550° TO 1600°F FROM .003  
TO .005 DEPTH. OIL QUENCH.  
TEMPER 20 MIN AT 350° F. HEAT  
TREATMENT METHOD IS FOR  
GUIDANCE EXCEPT THAT CASE DEPTH  
AND HARDNESS REQUIREMENTS ARE  
MANDATORY AND TIME AT TEMPERA-  
TURE SHALL NOT BE REDUCED BELOW  
THAT SPECIFIED. THE USE OF STRAIGHT  
CYANIDE BATH OR CARBO-NITRIDING  
PROCESSES SHALL NOT BE PERMITTED  
WITHOUT PRIOR APPROVAL OF THE CON-  
TRACTING OFFICER.
5. MIL-W-13855 SHALL APPLY.



ORIGINAL FSCM NO. 19205

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801CODE IDENT NO. 19204  
PART NO. 7790698

PHYSICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED		ORIGINAL DATE OF DRAWING 1 SEP 59		DEPT OF THE ARMY	
YP		DIMENSIONS ARE IN INCHES		DRAFTSMAN JP CHECKER 3 3		ROCK ISLAND ARSENAL	
TS		TOLERANCES ON		TRACER LRS CHECKER 615		ROCK ISLAND, ILL. 61201	
EL2		FRACTIONS DECIMALS ANGLES		ENGR 002 ENGR 002		DWD SIZE	
RA		±1/64 ±10°		SUBMITTED		7790698	
BH		MATERIAL		APPROVED BY ORDER OF THE		B	
APPLICATION		SEE NOTE 3		CHIEF OF ORDNANCE		SHEET OF	
NEXT ASSY USED ON		HEAT TREATMENT		H. F. [Signature]		PDC	
APPLY PART NO.		SEE NOTE 4		SCALE 2/1 UNIT WT			
DO NOT		FILE HARD					
APPLY PART NO.		SEE NOTE 5					
FINISH 5.3.1.2 OF MIL-STD-171							

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
A	REDRAWN AND REVISED	26 SEP 60	[Signature]
	SEE EO SA 25797		
B <sub>2</sub>	SEE EO SA 26825	8 NOV 63	[Signature]
C	(1-3) SEE EO SA 29262	18 MAY 66	[Signature]
D	(1-2) SEE EO 82048	11 MAR 68	[Signature]
E	(1) SEE EO HRD 92078-2	25 JUN 69	[Signature]
F	SEE EO HRD 02138	71 FEB 73	[Signature]
G	(2) SEE ERR HQR 40681	10 FEB 75	[Signature]
H	NOR WBS2022/79-03-26	79-04-01	SA R. H. [Signature]
J	NORW4S2051/840824 (ECPW5S2069 / 851223)	860121	[Signature]

NOTICE - WHEN GOVERNMENT DRAWINGS SPECIFICATIONS OR OTHER DATA ARE USED FOR ANY PURPOSE OTHER THAN IN CONNECTION WITH A DEFINITELY RELATED GOVERNMENT PROCUREMENT OPERATION, THE UNITED STATES GOVERNMENT HEREBY ASSUMES NO RESPONSIBILITY AND NO OBLIGATION WHATSOEVER, AND FURTHER THAT THE GOVERNMENT MAY HAVE FORMULATED SPECIFICATIONS OR OTHER DATA IS NOT TO BE ASSUMED BY IMPLICATION OR OTHERWISE AS IN ANY MANNER LICENSING THE HOLDER OR ANY OTHER PERSON OR CORPORATION, OR CONVEYING ANY RIGHTS OF PERMISSION TO MANUFACTURE, USE, OR SELL ANY PATENTED INVENTION THAT MAY IN ANY WAY BE ASSOCIATED HERETO.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
B		8 NOV 63	
C	REDRAWN & REVISED SEE EO SA 27441	2 NOV 64	<i>[Signature]</i>
D	(1) SEE EO SA 29262	18 MAY 66	<i>[Signature]</i>
E	(1-2) SEE EO 82048	11 MAR 68	<i>[Signature]</i>
F	(1) SEE EO HRD 92078-2	25 JUN 69	<i>[Signature]</i>
G	SEE EO HRD 02138	71 FEB 75	<i>[Signature]</i>
H	(3) SEE ERR HQR 40681	10 FEB 75	<i>[Signature]</i>
J	NOR W8S2022/79-03-26	79-04-01	SA B, J, LL
K	NORW4S2051/840824 (ECPW5S2069 / 851223)	860121	<i>[Signature]</i>

WIRE DIAMETER ----- .0300 ± .0005  
 COIL DIAMETER ( O.D. ) ----- .2375 ± .0025  
 FREE LENGTH ----- .680 REF  
 TOTAL COILS ----- 9 REF  
 DIRECTION OF HELIX ----- OPTIONAL  
 LOAD AT COMPRESSED LENGTH OF .410 ----- 4.40 LB ± .44 LB  
 LOAD AT COMPRESSED LENGTH OF .310 ----- 6.10 LB ± .61 LB  
 SPRING RATE ----- 16.40 LB/IN REF  
 SOLID LENGTH ----- .275 MAX  
 TYPE OF ENDS ----- OPEN ENDS GROUND  
 MANUFACTURE IN ACCORDANCE WITH MIL-S-13572, TYPE I, GRADE A.

# NOTES:

- HOLE DIA INTO WHICH SPRING FITS FREELY .245 MIN.
- ROD DIA OVER WHICH SPRING SLIDES FREELY .140 MAX.
- HEAT TREATMENT: STRESS RELIEVE AT 425 °F. TO 445 °F FOR 30 MIN, AFTER COILING.
- FINAL PROTECTIVE FINISH: FINISH 3.3.1 OF MIL-STD-171 WITH SUPPLEMENTARY PRESERVATIVE CONFORMING TO SPEC VV-L-800.
- LOAD REQUIREMENTS SHALL APPLY AFTER SPRING HAS BEEN COMPRESSED TO SOLID LENGTH 3 TIMES.

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
 U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
 DOVER, NEW JERSEY 07801

ORIGINAL FSCM NO. 19205

(USED WITH PLUNGER, BUTT PLATE - 7790698) (D1)

PART NO. 7790699

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 1 SEP 59		SPRING COMMAND	
YP				DRAFTSMAN	CHECKER	WEAPONS COMMAND	
TS		RIFLE, M14		J.P.	G.V.S.	MATERIAL COMMAND	
EL 2		D 7790686 RIFLE, M14		TRACER	CHECKER		
RA				TMS	WHS		
BH		NEXT ASSY USED ON		ENGINEER	ENGINEER		
		APPLICATION		SUBMITTED			
RH		DO NOT APPLY PART NO		APPROVED			
		AS SPECIFIED		D. A. Lusk			
		TOLERANCES ON DECIMALS ±					
		FRACTIONS ± ANGLES ±					
		MATERIAL: STEEL WIRE, SPEC QQ-W-470					
		HEAT TREATMENT					
		SEE NOTE 3					
		FINAL PROTECTIVE FINISH					
		SEE NOTE 4					

SPRING, HELICAL, COMPRESSION

CODE IDENT NO	DWG SIZE	
19204	B	7790699
SCALE	UNIT WT	SHEET 1 OF 1

NOTES:

1. FINISH 125/
2. BEFORE HEAT TREATMENT BRAZE WITH BRAZING ALLOY FED SPEC QQ-B-655 FS BALS1-3 OR FS BALS1-4.
3. HEAT TREATMENT:
  - A. SOLUTION HEAT TREAT TO T4 CONDITION.
  - B. AGE HARDEN TO T6 CONDITION.
4. DIMENSIONS SHOWN ARE FINAL DIMENSIONS AFTER APPLICATION OF FINAL PROTECTIVE FINISH. APPROX 50% OF COATING THICKNESS IS PENETRATION INTO BASE METAL AND 50% IS SURFACE BUILD-UP.
5.  $\phi$  -A- IS ESTABLISHED BY CENTERS OF .218 DIA  $\pm$  .008 HOLES (REF DWG D7790696).
6. FINISH 7.5 OF MIL-STD-171. COATING THICKNESS .0025  $\pm$  .0010. COATING MAY VARY IN COLOR FROM GRAY, 36118, TO BLACK, 37038 OF FED-STD-595.
7. MIL-W-13855 SHALL APPLY.

.010 MAX MISMATCH PERMISSIBLE.

BRAZE SEE NOTE 2

ALTERNATIVE ASSEMBLY (BRAZING)

.010 MAX MISMATCH PERMISSIBLE

BRAZE SEE NOTE 2

SECTION D-D

NOTE: DIMENSIONS -C- MAY BE ADJUSTED TO SUIT MANUFACTURE

PARTIAL SECTION C-C

SECTION B-B

.932 REF  
= A .006 (M)

SECTION A-A

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

ORIGINAL FSCM NO. 19205

-A- SEE NOTE 5

FOR LIST OF PARTS  
SEE ENGINEERING PARTS LIST 7790700

PART NO. 7790700

PHYSICAL PROPERTIES	
YP	
TS	
ELS	D7790686
SA	
BR	
NR	
APPLICATION	
DO NOT	APPLY PART NO.
DO	NO SPECIFIED

TOLERANCES ON ANGLES	
MATERIAL	
HEAT TREATMENT	
SEE NOTE 3	
FINAL PROTECTIVE FINISH	
SEE NOTE 6	

ORIGINAL DATE OF DRAWING	1 SEP 59
DRAWN BY	RHS
CHECKED BY	3
ENGINEER	W. S. W.
SUBMITTED	W. S. W.
APPROVED BY	W. S. W.
ORD CORPS	

PLATE ASSY,  
BUTT

DEPT OF THE ARMY  
U.S. ARMY WEAPONS  
COMMAND

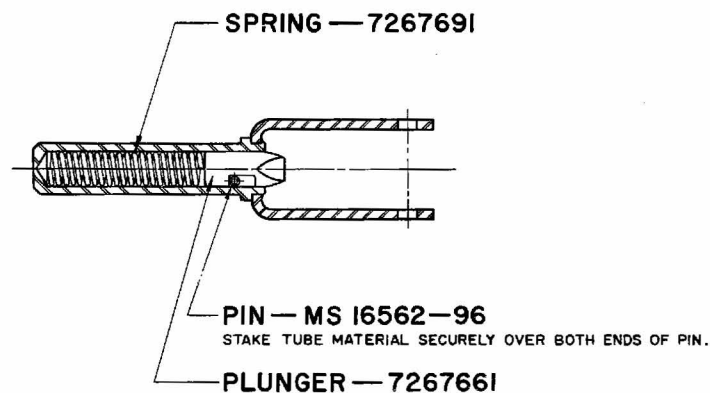
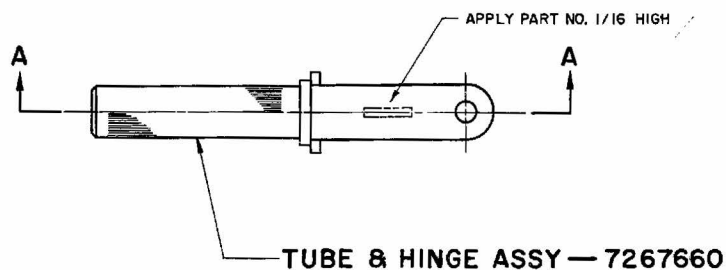
ROCK ISLAND, ILL. 61901

DWG NO. 7790700  
C  
SHEET 1 OF 1

SYN	DESCRIPTION	DATE	APPROVAL
J	NOR WSS2051/B40824 (ECP WSS2069/BS1223)	8/20/21	MIR
H	NOR WSS2022/79-03-26	79-04-01	SAO/ML
G	SEE EO HRD 02138	7/16/25	
F	(1) SEE EO HRD 92078-2	25 JUN 25	
E	SEE EO B2048	11 MAR 68	
D	(1) SEE EO SA29261	18 MAY 66	
C	SEE EO SA27502	8 JAN 65	
B	SEE EO SA26825	8 NOV 63	
A	REDRAWN AND REVISED	28 SEP 64	
	SEE EO SA28797		



NOTES - WITH GOVERNMENT DRAWING, SPECIFICATION, OR OTHER DATA ARE USED FOR ANY PURPOSE OTHER THAN IN CONNECTION WITH A GOVERNMENTALLY RELATED GOVERNMENT PROCUREMENT OPERATION, THE UNITED STATES GOVERNMENT THEREBY INCURS NO LIABILITY AND ANY OBLIGATION WHATSOEVER, AND THE FACT THAT THE GOVERNMENT MAY HAVE FORMULATED, FURNISHED, OR IN ANY WAY SUPPLIED THE SAID DRAWING, SPECIFICATION OR OTHER DATA IS NOT TO BE REGARDED AS AN OBLIGATION OR OTHERWISE AS IN ANY MANNER LIMITING THE HOLDER OR ANY OTHER PERSON OR CORPORATION, OR CONFERRING ANY RIGHTS OR PERMISSION TO MANUFACTURE, USE, OR SELL ANY PATENTED INVENTION THAT MAY IN ANY WAY BE RELATED THERETO.



SECTION A-A

C7790900

FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 7790900

CODE IDENT. NO. 00000

ORD PART NO. 7790900

PHYSICAL PROPERTIES		LAUNCHER GRENADE: F7267617 M76		TOLERANCES ON DECIMALS ANGLES FRACTIONS		ORIGINAL DATE OF DRAWING 10 MAR 60		REVISIONS	
YT									
TS									
EL2									
RA									
WH									
WH									
NEXT ASSY USED ON		HEAT TREATMENT		SUBMITTED TO		ENGINEER		DATE	
APPLICATION		FINAL PROTECTIVE FINISH		APPROVED BY ORDER OF THE CHIEF OF ORDNANCE		SCALE 2/1		UNIT WT	
DO NOT PER MIL - STD - 130 AS SPECIFIED				R. S. Henry		C		7790900	
				H. J. Lynch		C		SHEET 1 of 1	

HANDLE ASSEMBLY LATCHING

SPRINGFIELD ARMY  
ORDNANCE CORPS  
DEPT OF THE ARMY  
SPRINGFIELD 1, MASS.

7790900

C

SHEET 1 of 1

C 7790900



NOTES:

1. FINISH  $\sqrt{63}$  EXCEPT AS NOTED.
2. ALL EDGES SHALL BE BROKEN .005±.010 UNLESS OTHERWISE SPECIFIED.

3. HOLE  $\text{---A---}$  TO BE STRAIGHT, SMOOTH, AND FREE OF BURRS, RIDGES AND OTHER PROCESSING DEFECTS.

4. A TWO DIA CONCENTRIC FLUG HAVING DIAMETERS OF .4998 AND .404 AND HAVING A FLAT .181 FROM  $\text{---E---}$  OF .404 DIA SHALL PASS THROUGH "O" SHAPED OPENING LENGTH OF .4998 DIA SHALL BE 1.878 MIN.

5. MATERIAL: CORROSION RESISTING STEEL, STAINLESS, TYPE 416, CONDITION A, ASTM A 562, EXCEPT: COPPER .50 MAX, CHROMIUM 12.00-13.50, PHOSPHORUS .04 MAX, MUST BE HARDENABLE TO MINIMUM OF Rc 38 WHEN AIRCOOLED FROM 1800°-1850° F.

6. HEAT TREATMENT: BEFORE MACHINING, HEAT TO 1800°-1850° F, AIR COOL, TEMPER ONE HOUR AT HEAT TO BRINELL SPECIFIED. HEAT TREATMENT IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.

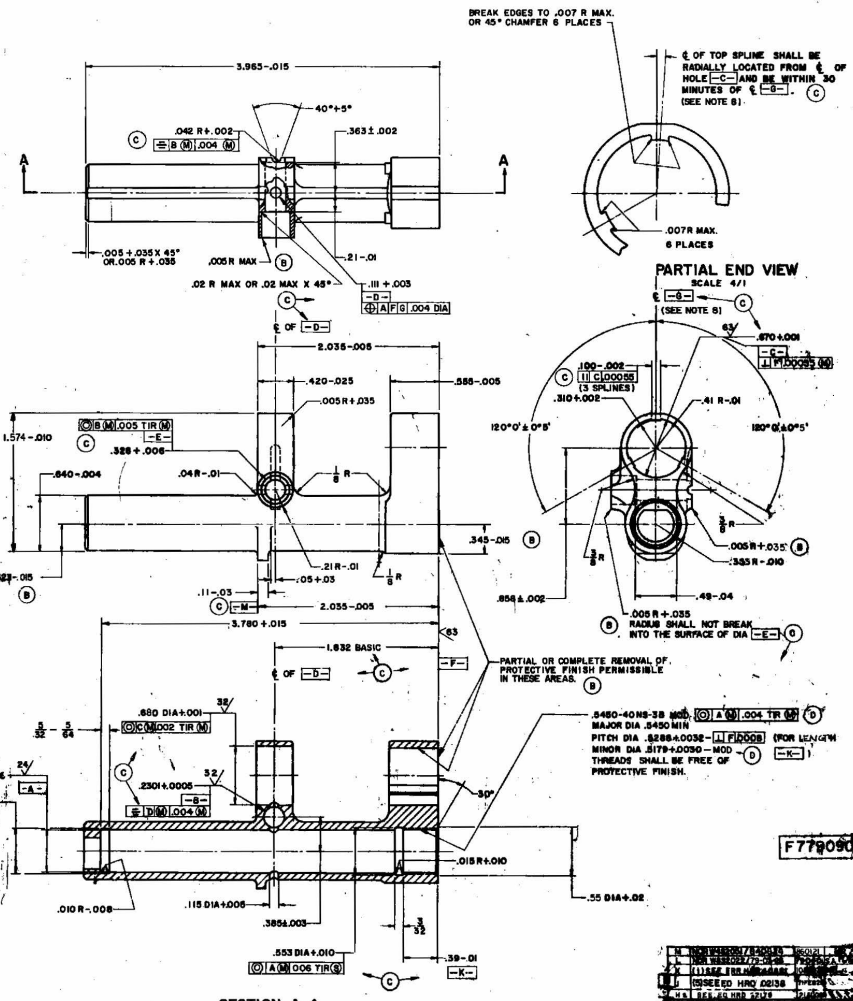
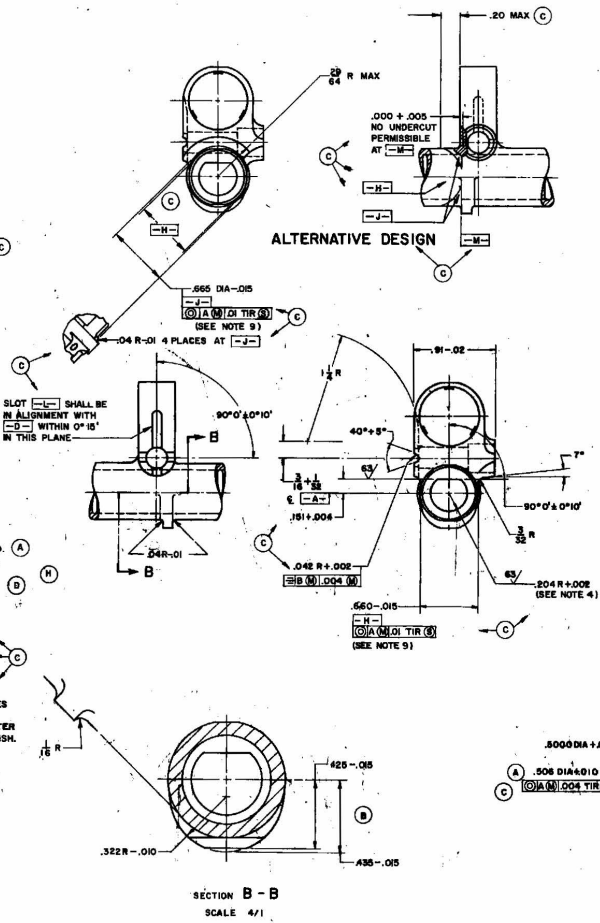
7. FINAL PROTECTIVE FINISH NO 3.2 OF 3.33 OF MS-STD-171 WITH SUPPLEMENTARY PRESERVATIVE CONFORMING TO VV-L-800.

8.  $\text{---E---}$  IS ESTABLISHED BY A LINE THROUGH THE CENTERS OF HOLES  $\text{---A---}$  AND  $\text{---C---}$ .

9. NO PORTION OF  $\text{---C---}$  SHALL FALL BELOW  $\text{---E---}$  REGARDLESS OF THE SIZES OF BOTH FEATURES AND THEIR CONCENTRICITY REQUIREMENTS RELATIVE TO  $\text{---A---}$ .

10. UNLESS OTHERWISE SPECIFIED, SURFACES REQUIRING 32 AND FINER ROUGHNESS HEIGHT RATINGS MAY BE PROCESSED AFTER APPLICATION OF FINAL PROTECTIVE FINISH. BRIGHT AREAS RESULTING FROM SUCH PROCESSING ARE PERMISSIBLE.

11. MIL-W-13859 SHALL APPLY.



ORIGINAL DESIGN ACTIVITY FSCM NO. 19205

SECTION A-A  
CURRENT DESIGN ACTIVITY FROM NO. 19205  
U.S. ARMY AMMUNITION RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

ITEM NO.	3336574	DESCRIPTION	HYDRAULIC CYLINDER
REV.	1	DATE	17 SEP 70
REV.	2	DATE	17 SEP 70
REV.	3	DATE	17 SEP 70
REV.	4	DATE	17 SEP 70
REV.	5	DATE	17 SEP 70
REV.	6	DATE	17 SEP 70
REV.	7	DATE	17 SEP 70
REV.	8	DATE	17 SEP 70
REV.	9	DATE	17 SEP 70
REV.	10	DATE	17 SEP 70
REV.	11	DATE	17 SEP 70
REV.	12	DATE	17 SEP 70
REV.	13	DATE	17 SEP 70
REV.	14	DATE	17 SEP 70
REV.	15	DATE	17 SEP 70
REV.	16	DATE	17 SEP 70
REV.	17	DATE	17 SEP 70
REV.	18	DATE	17 SEP 70
REV.	19	DATE	17 SEP 70
REV.	20	DATE	17 SEP 70
REV.	21	DATE	17 SEP 70
REV.	22	DATE	17 SEP 70
REV.	23	DATE	17 SEP 70
REV.	24	DATE	17 SEP 70
REV.	25	DATE	17 SEP 70
REV.	26	DATE	17 SEP 70
REV.	27	DATE	17 SEP 70
REV.	28	DATE	17 SEP 70
REV.	29	DATE	17 SEP 70
REV.	30	DATE	17 SEP 70
REV.	31	DATE	17 SEP 70
REV.	32	DATE	17 SEP 70
REV.	33	DATE	17 SEP 70
REV.	34	DATE	17 SEP 70
REV.	35	DATE	17 SEP 70
REV.	36	DATE	17 SEP 70
REV.	37	DATE	17 SEP 70
REV.	38	DATE	17 SEP 70
REV.	39	DATE	17 SEP 70
REV.	40	DATE	17 SEP 70
REV.	41	DATE	17 SEP 70
REV.	42	DATE	17 SEP 70
REV.	43	DATE	17 SEP 70
REV.	44	DATE	17 SEP 70
REV.	45	DATE	17 SEP 70
REV.	46	DATE	17 SEP 70
REV.	47	DATE	17 SEP 70
REV.	48	DATE	17 SEP 70
REV.	49	DATE	17 SEP 70
REV.	50	DATE	17 SEP 70
REV.	51	DATE	17 SEP 70
REV.	52	DATE	17 SEP 70
REV.	53	DATE	17 SEP 70
REV.	54	DATE	17 SEP 70
REV.	55	DATE	17 SEP 70
REV.	56	DATE	17 SEP 70
REV.	57	DATE	17 SEP 70
REV.	58	DATE	17 SEP 70
REV.	59	DATE	17 SEP 70
REV.	60	DATE	17 SEP 70
REV.	61	DATE	17 SEP 70
REV.	62	DATE	17 SEP 70
REV.	63	DATE	17 SEP 70
REV.	64	DATE	17 SEP 70
REV.	65	DATE	17 SEP 70
REV.	66	DATE	17 SEP 70
REV.	67	DATE	17 SEP 70
REV.	68	DATE	17 SEP 70
REV.	69	DATE	17 SEP 70
REV.	70	DATE	17 SEP 70
REV.	71	DATE	17 SEP 70
REV.	72	DATE	17 SEP 70
REV.	73	DATE	17 SEP 70
REV.	74	DATE	17 SEP 70
REV.	75	DATE	17 SEP 70
REV.	76	DATE	17 SEP 70
REV.	77	DATE	17 SEP 70
REV.	78	DATE	17 SEP 70
REV.	79	DATE	17 SEP 70
REV.	80	DATE	17 SEP 70
REV.	81	DATE	17 SEP 70
REV.	82	DATE	17 SEP 70
REV.	83	DATE	17 SEP 70
REV.	84	DATE	17 SEP 70
REV.	85	DATE	17 SEP 70
REV.	86	DATE	17 SEP 70
REV.	87	DATE	17 SEP 70
REV.	88	DATE	17 SEP 70
REV.	89	DATE	17 SEP 70
REV.	90	DATE	17 SEP 70
REV.	91	DATE	17 SEP 70
REV.	92	DATE	17 SEP 70
REV.	93	DATE	17 SEP 70
REV.	94	DATE	17 SEP 70
REV.	95	DATE	17 SEP 70
REV.	96	DATE	17 SEP 70
REV.	97	DATE	17 SEP 70
REV.	98	DATE	17 SEP 70
REV.	99	DATE	17 SEP 70
REV.	100	DATE	17 SEP 70

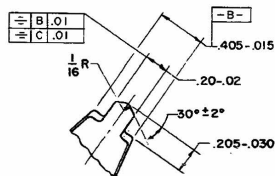
CYLINDER, GAS

7790902

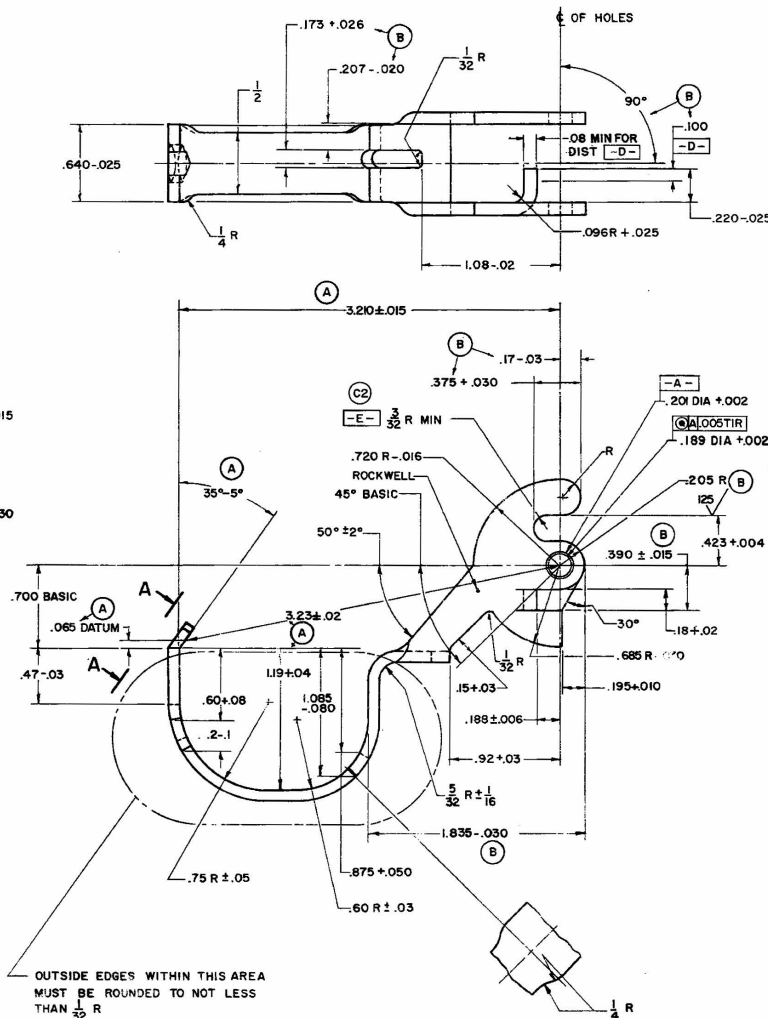
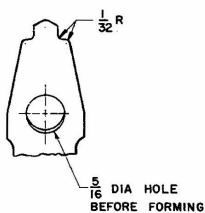
3 DUPLICATE ORIGINAL

# NOTES

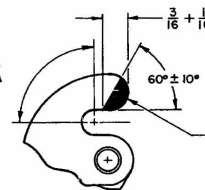
1. FINISH  $125\sqrt{}$  SHEARED SURFACES  $250\sqrt{}$  EXCEPT AS NOTED.
2. ALL BURRS SHALL BE REMOVED AND ALL EDGES SHALL BE ROUNDED TO  $1/64$  R MAX EXCEPT WHERE OTHERWISE SPECIFIED.
3. HEAT TREATMENT: HEAT AT  $1525^{\circ}$  TO  $1550^{\circ}$  F OIL QUENCH. TEMPER 30 MINUTES AT HEAT TO ROCKWELL SPECIFIED. HEAT TREATMENT IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
4. FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.
5. MIL-W-13855 APPLIES.



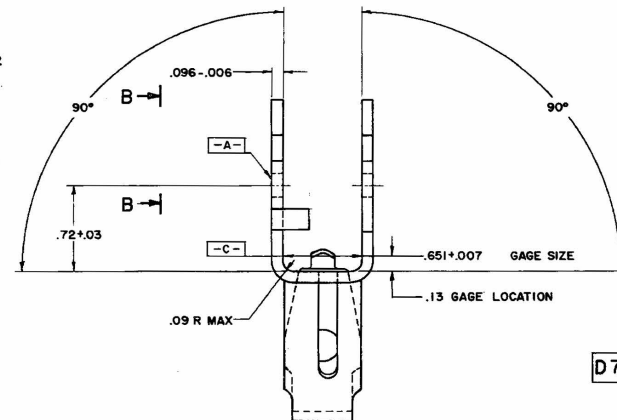
VIEW A-A



(C) RADIUS  $125\sqrt{}$  SHALL  $125\sqrt{}$  IN THIS AREA



VIEW B-B



ORIGINAL FSCM NO. 19205

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

CODE IDENT NO. 19204  
PART NO. 7790990

PHYSICAL PROPERTIES	RIFLE, M14 NM	TOLERANCES ON DIMENSIONS	30 SEP 60
ITEM		UNLESS 2:1	
SIZE	D7790195 RIFLE, M14	FRACTIONS 1/64	
MATERIAL	STEEL, ASTM A684		
FINISH	CHPBN 1060 OR 1065		
HEAT TREATMENT	SEE NOTE 3		
APPLICATION	DO NOT APPLY PART NO.		
FINAL PROTECTIVE FINISH	SEE NOTE 4		

GUARD, TRIGGER

DEPT OF THE ARMY	ROCK ISLAND ARSENAL
7790990	7790990
1	1

1. FINISH 125/ ALL OVER. (G) (B2)  
2. ALL EDGES SHALL BE BROKEN  
.005 +.010 UNLESS OTHERWISE  
SPECIFIED.  
3. C-H ESTABLISHED BY -A- AND (A)

4. MATERIAL:  
 A FOR WROUGHT MATERIAL:  
 STEEL, SPEC ASTM A304, A322, A331, 4140.  
 B FOR PRECISION CASTING:  
 STEEL, MIL-S-22141; IC-4140 EXCEPT;  
 CARBON .43 TO .53 PERCENT, TENSILE  
 TEST SHALL NOT APPLY.  
 (DI) CLASSIFICATION AND INSPECTION OF  
 INVESTMENT CASTINGS TO BE IN  
 ACCORDANCE WITH CLASS 2, GRADE A  
 EXCEPT GROSS FINISHING AREA TO BE  
 CLASS 1, GRADE A, SPEC MIL-C-6021.  
 (SEE SHEET 2)

5. HEAT TREATMENT (FOR MATERIALS A & B): BEFORE MACHINING, HEAT AT 1550°F. TO 1575°F. OIL QUENCH. TEMPER 30 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.

6. -D- (TOP SLOT) SHALL BE IN ALIGNMENT WITH E (TOP SPLINE) WITHIN 2°. (SEE SH1, C-3)

7. MIL-W-13855 SHALL APPLY.

7. MIL-W-13855 SHALL APPLY

Technical drawing of a mechanical part with the following dimensions and features:

- Top horizontal dimension: .125 ± .010
- Top right horizontal dimension: .265 ± .010
- Top right horizontal dimension: .04 R - .01
- Top right horizontal dimension: .18 ± .003
- Top right horizontal dimension: 1/8 R 4 PLACES
- Left vertical dimension: .515 ± .005
- Left vertical dimension: .573 ± .008
- Left vertical dimension: .78 ± .02
- Bottom left feature callout: (A) with arrows pointing to a hole and a slot.
- Bottom left feature callout: (F) with an arrow pointing to a hole.
- Bottom horizontal dimension: .420 ± .005
- Bottom horizontal dimension: .45 ± .02
- Bottom right horizontal dimension: .670 ± .005
- Feature callouts:
  - Top left: SEE SHEET 2 FOR ALTERNATIVE DESIGNS
  - Bottom left:  $\begin{matrix} \text{C} & \text{Q} & .006 & \text{Q} \\ \text{---} & & & \text{---} \end{matrix}$
  - Bottom left:  $\begin{matrix} \text{C} & \text{---} & .005 \end{matrix}$
  - Bottom left:  $\begin{matrix} \text{L} & \text{Q} & .01 & \text{Q} \\ \text{---} & & & \text{---} \end{matrix}$

Technical drawing of a valve assembly showing a cross-section of the valve body and a detail view of the top flange. The detail view shows a flange with a central hole and a raised face. Dimensions include a total height of  $.760 \pm .015$  and a raised face height of  $.015 \text{ R}-.010 \text{ OR } .015-.010 \text{ X } 45^\circ \text{ BOTH SIDES}$ . A feature control frame at the top left indicates a circular feature with a diameter of  $\varnothing .015$  and a circular runout tolerance of  $\varnothing .015$ .

SECTION D-D

PARTIAL SECTION K-K  
SCALE 4/1

SECTION H-H

DETAIL M  
SCALE 4/1

— SEE DETAIL M

DOVETAIL CHAMFERS  
SCALE 4/1

DETAIL L

SECTION C - C

SEE SHEET 2 FOR ALTERNATIVE DESIGN

SCALE 4/1  
SEE SHEET 2 FOR  
ALTERNATIVE DESIGNS

— SEE DETAIL L

ORIGINAL DESIGN ACTIVITY FSCM NO.19205  
CURRENT DESIGN ACTIVITY FSCM NO.19200  
US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

CODE IDENT NO. 19204  
PART NO. 7791053

SUPPRESSOR,  
FLASH

F 7791053

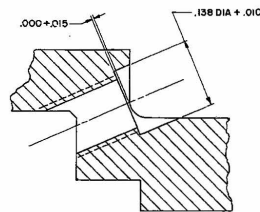
J	NOR W252025	18-02-1984-04-20	18-02-1984-04-20
H	NOR W8522027/9-03-26	7904-01 SA	7904-01 SA
G	(3) SEE ERR HOR 4068	02 FEB 79	02 FEB 79
F	SEE EO HRD 02130	71 FEB 79	71 FEB 79
E	(1) SEE EO HRD 92078-2	25 JAN 79	25 JAN 79
D	(1-4) SEE EO - 82048	1 PMR 68	1 PMR 68
C	(1) SEE EO RIA - 14001	2-17-67	2-17-67
B	(1-4) SEE EO SA 29262	2 MAR 66	2 MAR 66
A	SEE EO SA 26305	24 JUN 65	24 JUN 65
APR	DESCRIPTION	DATE	APPROV

7791053

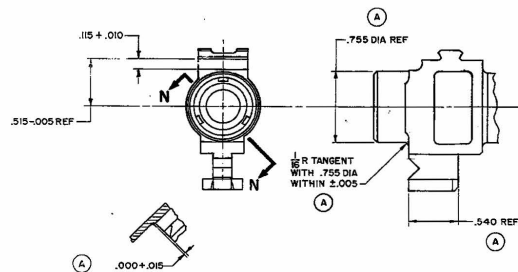
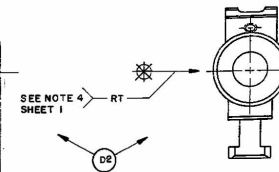
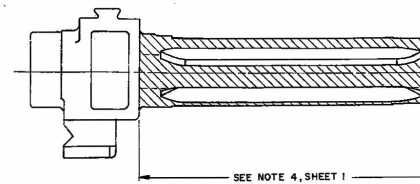
		2
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POSITION NUMBERS	NUMBER OF POSITIONS	NO. OF FILMS	NO. OF VIEWS PER FILM	FILM SIZE
1	1	1	30 TO 33	14 X 17

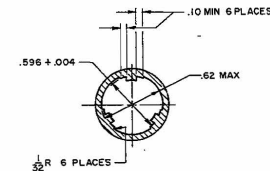
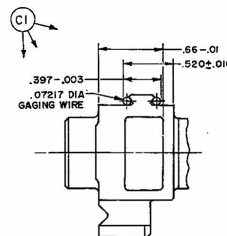
NOTES:  
ALL DIMENSIONS AND REQUIREMENTS ON SHEET 1 SHALL APPLY EXCEPT AS SPECIFIED HEREON.



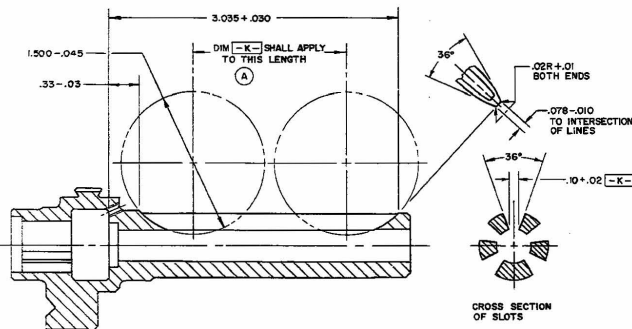
DETAIL P  
SCALE 10/1



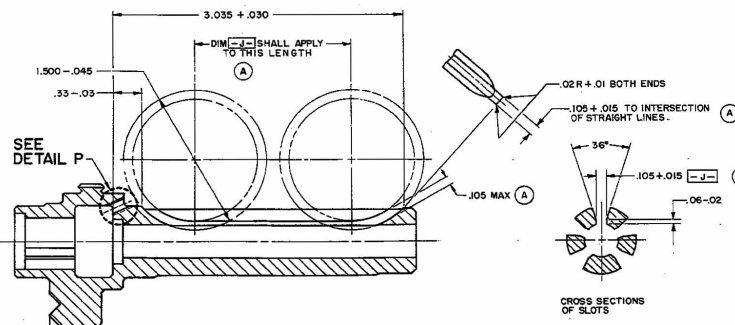
PARTIAL SECTION N-N



SECTION C - C  
SEE SHEET 1



SECTION A - A  
SEE SHEET 1



SECTION A - A  
SEE SHEET 1

ORIGINAL DESIGN ACTIVITY FSCM NO.19205  
CURRENT DESIGN ACTIVITY FSCM NO.19200  
US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

CODE: DENG NO. 19204  
PART NO. 7791053

PHYSICAL PROPERTIES	DESIGNATION	ORIGINAL DATE 30 SEP 60
1. MATERIAL	SEE SHEET 1.	DATE 2/25/61
2. HEAT TREATMENT	SEE SHEET 1.	DATE 2/25/61
3. FINISH	SEE SHEET 1.	DATE 2/25/61
4. APPLICATION	SEE SHEET 1.	DATE 2/25/61
5. DO NOT APPLY PART NO.	SEE SHEET 1.	DATE 2/25/61

SUPPRESSOR,  
FLASH  
(ALTERNATIVE DESIGNS)

DESIGNER: [illegible]  
CHECKER: [illegible]  
DATE: 2/25/61  
SCALE: 2/1  
UNIT: INCH

F7791053

F 7791053

D

C

B

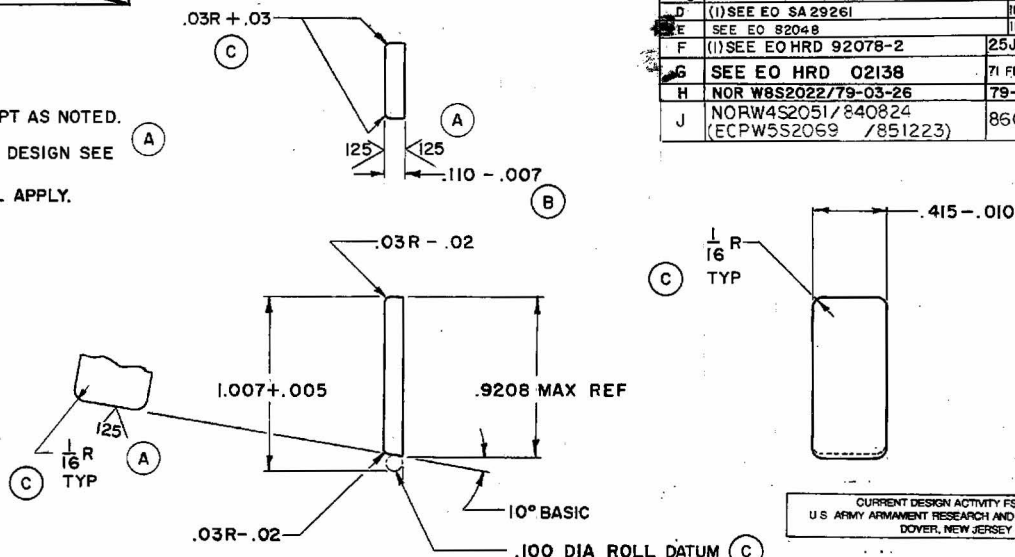
A

00 FORM 1176  
APR 54

NOTICE: This drawing, specification, or other data is not to be used for any purpose other than in connection with the Government procurement contract, and the fact that the Government may have furnished, furnished, or supplied the said drawings, specifications or other data is not to be construed as an acknowledgment of any error in the drawing or any other portion of the contract, or as an acknowledgment of any error in the drawing or any other portion of the contract, or as an acknowledgment of any error in the drawing or any other portion of the contract.

NOTES:

1. FINISH 250/ EXCEPT AS NOTED.
2. FOR ALTERNATIVE DESIGN SEE DWG D7790197.
3. MIL-W-13855 SHALL APPLY.



87790198

REVISIONS			
REV	DESCRIPTION	DATE	APPROVAL
A	SEE E.O. SA 25007	23 JAN 55	
B	SEE E.O. SA 25967	23 DEC 60	
C	SEE E.O. SA 26221	11 MAR 63	
D	(1) SEE EO SA 29261	18 MAY 66	
E	SEE EO 82048	11 MAR 68	
F	(1) SEE EO HRD 92078-2	25 JUN 69	
G	SEE EO HRD 02138	71 FEB 75	
H	NOR W8S2022/79-03-26	79-04-01	
J	NORW4S2051/840824 (ECPW5S2069 /851223)	860121	

CURRENT DESIGN ACTIVITY FSCM NO 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

ORIGINAL FSCM NO. 19205

CODE IDENT NO. 19204

PART NO. 7790198

PHYSICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED		ORIGINAL DATE	
YP	TS	DIMENSIONS ARE IN INCHES	TOLERANCES ON FRACTIONS DECIMALS ANGLES	OF DRAWING	12 JUN 1958
EL2	RA	2 1/64		DRAWN BY R.T.K.	CHECKED J.K.
BH	RH	MATERIAL STEEL, FED SPEC	QQ-S-700: 1050.	TRACER C.F.J.	CHECKED J.K.
APPLICATION		HEAT TREATMENT	AT ASSEMBLY	APPROVED BY ORDER OF THE	DIR OF ARMS
DO NOT	APPLY PART NO.	FINAL PROTECTIVE FINISH	AT ASSEMBLY	APPROVED BY ORDER OF THE	DIR OF ARMS

PLATE,  
MAGAZINE  
LATCH

DEPT OF THE ARMY  
U.S. ARMY WEAPONS  
COMMAND  
ROCK ISLAND, ILL 61201

QW SIZE  
B 7790198  
SHEET 1 OF 1

R. M. H.

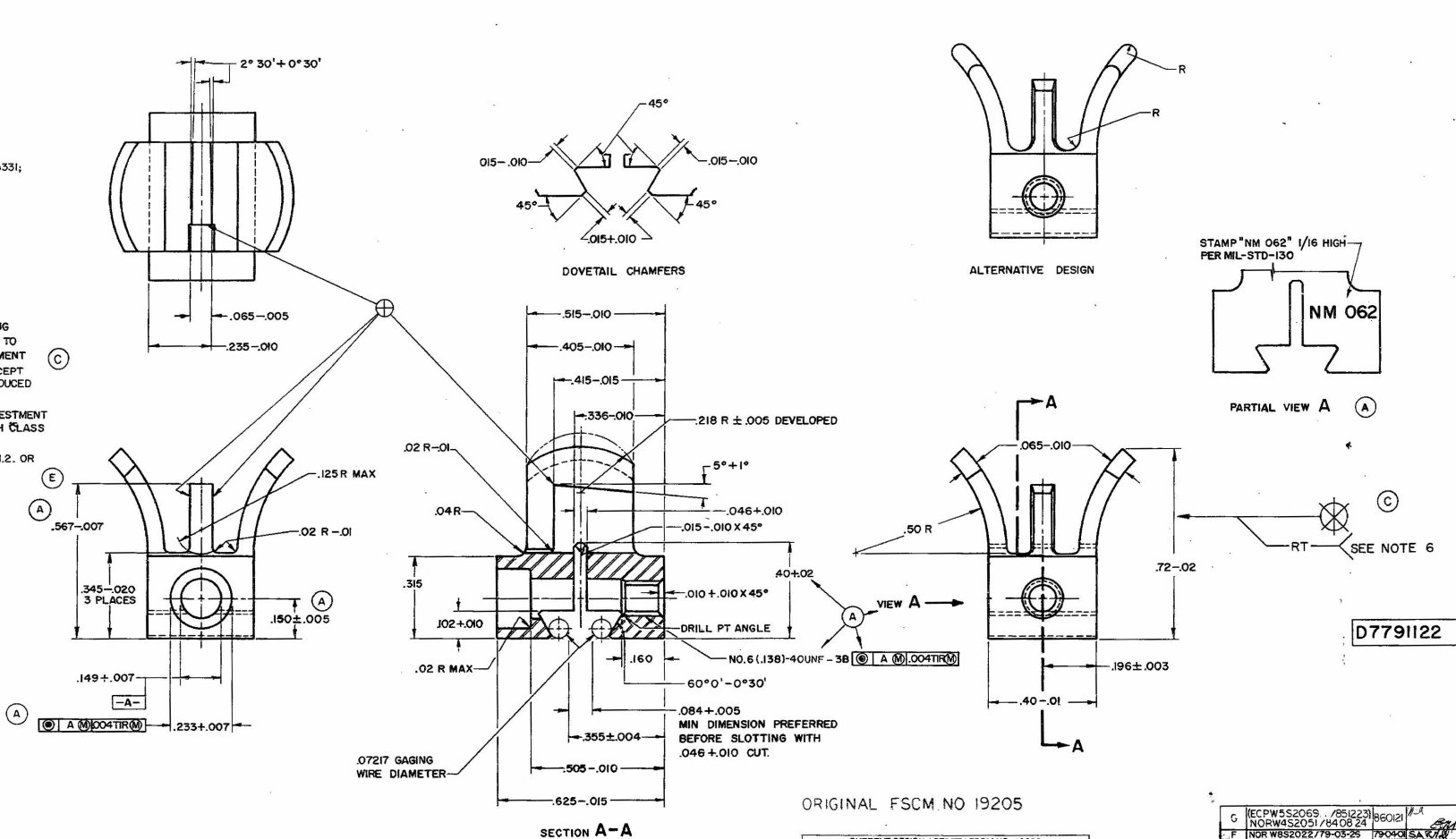
1. FINISH 125/  
2. ALL EDGES SHALL BE BROKEN  
.005+.010 UNLESS OTHERWISE  
SPECIFIED.  
3. EDGES TO BE SHARP TO  
DO3 R MAX AND FREE OF BURRS.  
4. MATERIAL:  
A. FOR WROUGHT MATERIAL:  
STEEL, SPEC ASTM A304, A322, A331;  
8640, 8740 OR 4150  
B. FOR PRECISION CASTING:  
STEEL, FED STD NO. 66, 4150  
EXCEPT: CARBON .45-.57  
PERCENT  
SILICON .20-.80  
PERCENT  
5. HEAT TREATMENT:  
(FOR MATERIALS A & B)  
HEAT TO 1550° TO 1575° FOR  
30 MINUTES. QUENCH IN CIRCULATING  
OIL. TEMPER 30 MINUTES AT HEAT TO  
HARDNESS SPECIFIED. HEAT TREATMENT  
METHOD IS FOR GUIDANCE ONLY EXCEPT  
TEMPERING TIME SHALL NOT BE REDUCED  
BELOW THAT SPECIFIED.  
6. CLASSIFICATION & INSPECTION OF INVESTMENT  
CASTINGS TO BE IN ACCORDANCE WITH CLASS  
3, GRADE C, MIL-STD-2175  
7. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2. OR  
5.3.2.2. OF MIL-STD-171.  
8. MIL-W-13855 SHALL APPLY.

D

C

B

A



ORIGINAL FSCM NO 19205

CURRENT DESIGN ACTIVITY FSCM NO 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

PART NO. 7791122

G	ICCPW5S2069..7851223	860121	1.1
F	NORW4S2051/840824		
E	NORW5S2022/779-0025	780408	SAK
D	1215E ERR NOR 408810 FEB 78		
C	SEE ED HSD 0215B	77FEB25	V.L.
B	11-315EE EQ HSD 92078-2	24JAN87	SAK
A	REF ED NO SA 25605	2000TH	SAK
A	REF ED NO SA 25605	2000TH	SAK

PHYSICAL PROPERTIES	TOLERANCES ON DECIMALS 0.01	ORIGINAL DATE OF DRAWING
1. MATERIAL	FRACIONS 1/64	16 NOV 61
2. HEAT TREAT		
3. APPLICATION		
4. DO NOT		
5. APPLY PART NO		
6. FINAL PROTECTIVE FINISH		
7. SEE NOTE 7		

REVISIONS	DATE	APPROVAL
1. 16 NOV 61		
2. 16 NOV 61		
3. 16 NOV 61		
4. 16 NOV 61		
5. 16 NOV 61		
6. 16 NOV 61		
7. 16 NOV 61		
8. 16 NOV 61		
9. 16 NOV 61		
10. 16 NOV 61		

SIGHT, FRONT

7791122

D

RMH

## NOTE:

1. STEEL, CARBON, 1050, 1141  
ASTM A108

2. FINISH 63/ EXCEPT AS NOTED.

3. ALL CORNERS AND EDGES SHALL BE SHARP TO .005 R  
MAX UNLESS OTHERWISE SPECIFIED.

4. HEAT TREATMENT: HEAT TO 1525°-1550° F. OIL QUENCH. TEMPER  
20 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT  
IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE  
REDUCED BELOW THAT SPECIFIED.

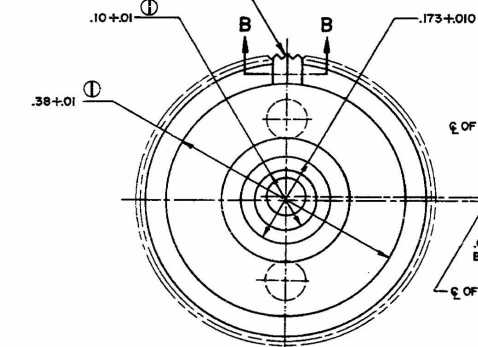
5. ① DIMENSIONS TO BE CONCENTRIC WITH  $\square A$  WITHIN .005 TIR.

6. "V" NOTCH SHALL BE ON SAME CENTERLINE AS .064 DIA+.002 HOLES WITHIN  
.020 AND SHALL BE LOCATED AS SHOWN IN RELATION WITH  
CENTERLINE OF DIA "B".

7. SURFACES SHALL BE FREE OF PROTECTIVE FINISH.

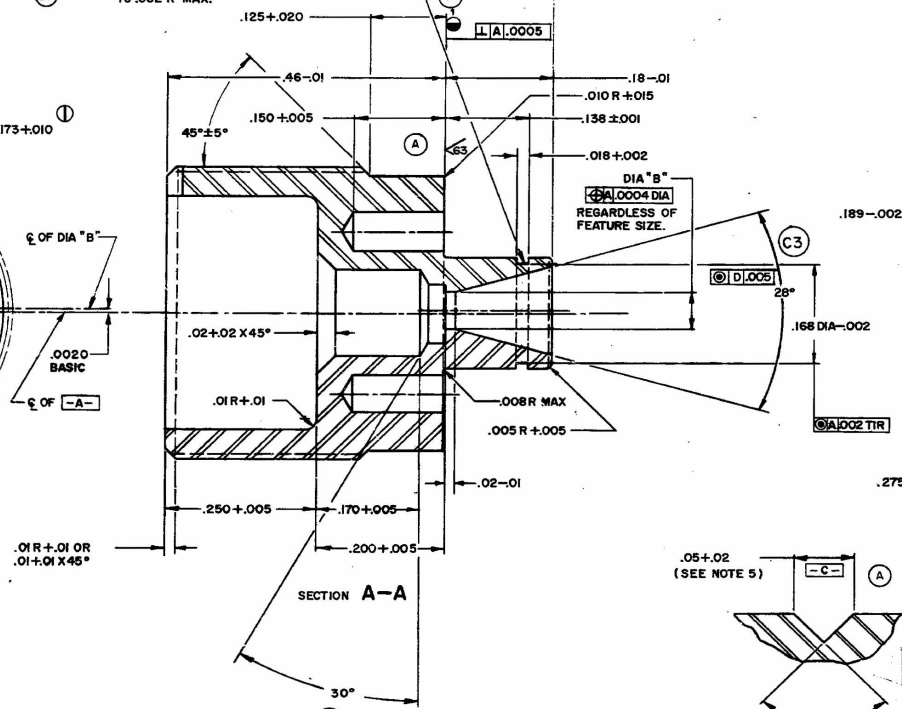
8. FINAL PROTECTIVE FINISH: FINISH 5.3.12 OR 5.3.2.2 OF  
MIL-STD-171.

KNURL .160 DP CLASS I  
TOL STR PER ANS  
B94.6-1961.



9. MIL-W-13855 SHALL APPLY.

CORNERS AND EDGES OF RETAINER GROOVE  
SHALL BE FREE FROM BURRS AND SHARP  
TO .002 R MAX.



PART NO.	PEEP SIZE OF PEEP HOLED MARKING	
7791131	.0595±.0025	595
7791281	.0520±.0025	520

PHYSICAL PROPERTIES	TOLERANCES ON DIMENSIONS	APPROVED FOR THE
7791132	RIFLE 100-100	SEE NOTE 1
AXOS-73	HEAT TREATMENT	SEE NOTE 4
DO NOT	FINAL PROTECTIVE FINISH	SEE NOTE 5

PART NO. (SEE TABULATION)

ORIGINAL DATE 15 DEC 61

DATE OF REVISION

REVISIONS

REVISIONS

REVISIONS

REVISIONS

REVISIONS

REVISIONS

REVISIONS

REVISIONS

EYEPiece

CODE IDENT NO. 19205

SPRINGFIELD ARMOY,  
SPRINGFIELD 1, MASS.

7791131

1

1

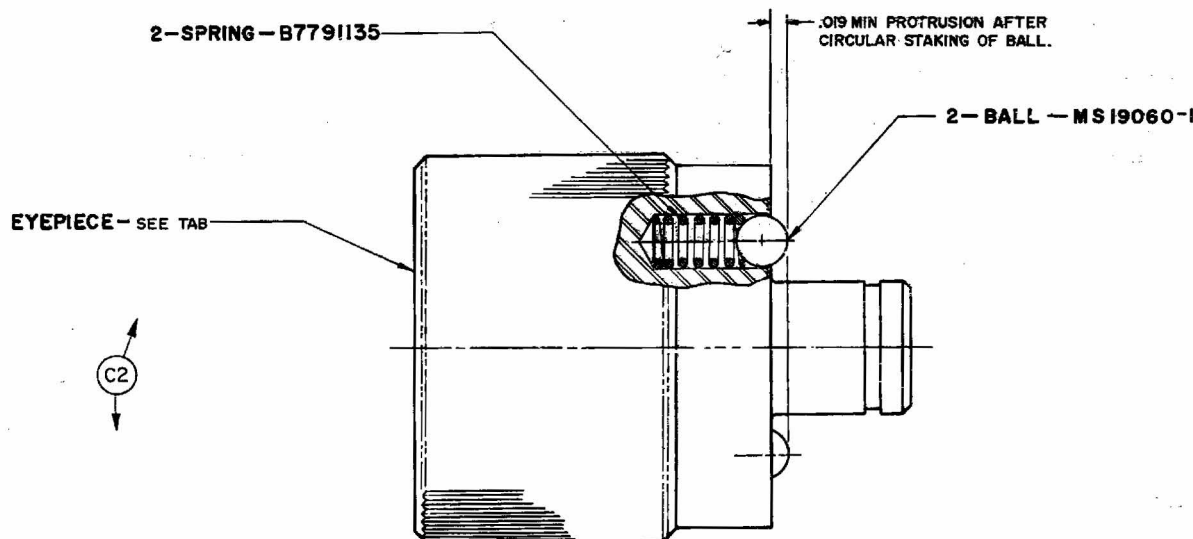
1



1. MIL-W-13855 SHALL APPLY.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
A	REF EO NO. SA 26594	18NOV63	<i>[Signature]</i>
B	REF EO NO. SA 27588	30OCT64	<i>[Signature]</i>
C	N-2)SEE EO RIA-13958	2-18-67	<i>[Signature]</i>
D	(I) SEE EO HRD 92078-2	25JUN69	<i>[Signature]</i>
E	SEE EP HRD 02138	71 FEB 25	<i>[Signature]</i>
F	NOR W8S2025/79-03-05	79-03-21	<i>[Signature]</i>
G	NORW452051/ 84 0824 (ECPW552069 / 851223)	860121	<i>[Signature]</i>
H	NOR W6S0060/860613 (ECP W6S2066/861215)	981102	<i>[Signature]</i>

C 7791132



C 7791132

PART NO.	EYEPiece (SEE DWG D7791131)
7791132-1	7791131
7791132-2	7791281

(C1)

SEE EPL - 7791132 -1 & 7791132-2 (DI)

CURRENT DESIGN ACTIVITY CAGE CODE 19200  
U.S. ARMY  
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER  
PICATINNY ARSENAL, NEW JERSEY 07806-5000

PART NO. SEE TABULATION

[illegible]

1

4

3

2

1

# NOTES:

1. SLIDING FIT IS REQUIRED BETWEEN EYEPiece AND APERTURE WITH NO PERCEPTIBLE LOOSENESS.

2. PEEP HOLE C SHALL BE DISPLACED VERTICALLY .0036 MIN TO .0044 MAX WHEN THE EYEPiece IS ROTATED 180° FROM ONE ENGAGED POSITION (BALLS IN "V" NOTCH) TO THE OTHER.

3. THE EYEPiece SHALL REMAIN IN CONTACT WITH REAR OF THE APERTURE WHEN INDEXED. EYEPiece SHALL INDEX SMOOTHLY AND BE POSITIVELY RETAINED AT EACH POSITION.

4. THE EYEPiece AND APERTURE ARE A MATCHED SET AND SHOULD NOT BE DISASSEMBLED UNLESS REPLACEMENT OF PARTS IS NECESSARY. REPLACEMENT OF APERTURE ASSEMBLY COMPONENTS SHOULD BE DONE ONLY WITH SELECTIVE ASSEMBLY.

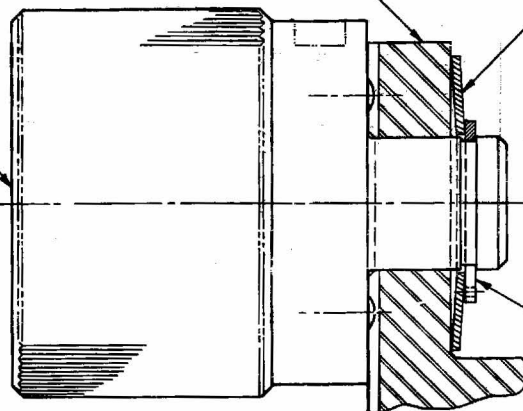
5. MIL-W-13855 SHALL APPLY.

APERTURE-D7791134

SPRING-B7791136

EYEPiece ASSY- SEE TAB

C2



RING-MS 16624-18

C7791133

PART NO.	MARKING	STOCK NO.	EYEPiece ASSY (SEE D7791132)
7791133	595	1005-864-2926	7791132-1
7791282	520	1005-864-2928	7791132-2

C1

E

SEE EPL 7791133 & 7791282 D1

<b>PHYSICAL PROPERTIES</b> VP TB EL 2 RA BN IN		J9386974 NM-30R-MI RIFLE, MN-NM	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DECIMALS FRACTIONS MATERIAL HEAT TREATMENT FINAL PROTECTIVE FINISH	ORIGINAL DATE OF DRAWING: 15 DEC-61 DESIGNED BY: JER CHECKED BY: RAH DRAWN BY: JER CHECKED BY: RAH APPROVED BY: [Signature] APPROVED BY: [Signature] SCALE: 10/1 UNIT: WT	<b>APERTURE ASSY</b> CODE IDENT NO. 19205 SCALE: 10/1 UNIT: WT	CURRENT DESIGN ACTIVITY CAGE CODE 19200 U.S. ARMY ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER PICATINNY ARSENAL, NEW JERSEY 07806-5000 PART NO. (SEE TABULATION) SPRINGFIELD ARMOY, SPRINGFIELD 1, MASS. C7791133
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3

2

1

C7791133

B



A

- 1. FINISH 12/5 EXCEPT AS NOTED.
- ALL CORNERS AND EDGES SHALL BE BROKEN  
1.00%±.001 UNLESS OTHERWISE SPECIFIED.
- 2. STEEL, CMPSN 1127 THRU 1141 FORDING SPEC MIL-S-13096,  
STEEL TURNING, SEAMLESS, GRADE 100, A18-4515  
OR  
STEEL, CMPSN 1141 PER ASTM-A-108.
- 3. HEAT TREATMENT: HEAT TO 1525°-1550°F. OIL QUENCH.  
TEMPER 20 MINUTES AT HEAT TO HARDNESS SPECIFIED.  
HEAT TREATMENT IS FOR GUIDANCE EXCEPT THAT TEMPERING  
TEMPER 20 MIN. NOT REQUIRED IF HARDNESS SPECIFIED.
- 4. DIMENSION SHALL BE ADJUSTED TO OBTAIN A SLIDING FIT (WITH NO  
PERCEPTIBLE LOOSENESS), WITH EPISODE REF. NO. 679131,  
DIRECTION 1-85-002. DIMENSION 1/8 DIA-100 WHEN  
1/8 DIA-100 IS PURCHASED.
- 5. SURFACES SHALL BE FREE OF PERCEPTIBLE FINISH.
- 6. DIMENSION SHALL BE ADJUSTED DURING FINAL  
ASSEMBLY TO OBTAIN A SLIDING FIT (WITH NO  
PERCEPTIBLE LOOSENESS), WITH EPISODE REF. NO. 679131,  
DIRECTION 1-85-002.
- 7. FINAL PROTECTIVE FINISH:  
FINISH 5.3-1.2 OF MIL-STD-171.
- 8. MIL-N-3885 SHALL APPLY.

STN	DESCRIPTION	DATE	APPROVAL
L	REDRAWN WITH CHANGE NOR W650060/860613 (ECP W652066/861215)	881102	ORF173



CUT 17 SPACES ——— MODIFIED ⊕  
NUTTALL 20 DEGREE STUB TEETH  
220 TEETH IN COMPLETE CIRCLE  
50 PER INCH .0628 CIRCULAR PITCH  
2.200 PITCH RADIUS.  
ACCUMULATED BUILDUP OF TOLERANCE IN  
CIRCULAR PITCH SHALL NOT EXCEED  
.005 IN 7 TEETH.

		MECHANICAL PROPERTIES		DO NOT SCALE DRAWING	
		TT		UNLESS OTHERWISE SPECIFIED	
		TS		DIMENSIONS ARE IN INCHES	
		EL2		TOLERANCES ON DECIMALS: ±.010	
		RA		ANGLES ± 1°	
		BH		THIRD ANGLE PROJECTION	
J2396974 RIFLE MP4-1M		DR			
C7791133		OR			
NEXT ASST		USED ON		A706-73	
APPLICATION					

PART NO. 7791134			
SPRINGFIELD ARMSORY, SPRINGFIELD 1, MASS.			
APERTURE			
SIZE	CODE IDENT NO.		
F	19205	7791134	
SCALE 5/1	UNIT WT.	A02	SHEET 1 OF 1

DRAWING SIZE C 4

3

2

1

## NOTES:

1. EACH SPRING IN A RANDOM SAMPLE SELECTED FOR INSPECTION (AFTER HEAT TREATMENT) SHALL BE COMPRESSED TO .086 THREE TIMES PRIOR TO GAGING.
2. MIL-S-13572 TYPE I, GRADE B, SHALL APPLY.
3. MATERIAL:  
WIRE, STEEL, SPEC QQ-W-470.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
H	REDRAWN WITH CHANGE NOR W6S0060/860613 (ECP W6S2066/861215)	881102	ON V Z EAM

DIAMETER OF WIRE ..... .0120  $\pm$  .0005  
 DIAMETER OF COIL (O.D.) ..... .060  $\pm$  .002  
 FREE LENGTH ..... .133 REF  
 ACTIVE COILS ..... 5 REF  
 TOTAL COILS ..... 7 REF  
 DIRECTION OF HELIX ..... R.H. OR L.H.  
 LOAD AT COMPRESSED LENGTH OF ..... .114 = 1.0 LB  $\pm$  .10 LB  
 LOAD AT COMPRESSED LENGTH OF ..... .089 = 2.4 LB  $\pm$  .25 LB  
 SPRING RATE ..... 54 LB/IN REF  
 SOLID LENGTH ..... .086 MAX  
 TYPE OF ENDS ..... CLOSED & GROUND

## SPECIAL DATA

HOLE DIA INTO WHICH SPRING FITS FREELY ---- .064 MIN  
 ROD DIA OVER WHICH SPRING SLIDES FREELY --- MAX

CURRENT DESIGN ACTIVITY CAGE CODE 19200  
 U.S. ARMY  
 ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER  
 PISCATAWAY ARSENAL, NEW JERSEY 07806-5000

(USED WITH EYEPiece ASSY-7791132)

PART NO. 7791135

		MECHANICAL PROPERTIES		DO NOT SCALE DRAWING		ORIGINAL DATE OF DRAWING		SPRINGFIELD ARMORY, SPRINGFIELD 1, MASS.	
				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		15 DEC 61			
		YP		TOLERANCES ON DECIMALS *		DRAFTSMAN		CHECKER	
		TS		FRACTIONS * ANGLES *		DSK		RAH	
		EL2		THIRD ANGLE PROJECTION		ENGR		ENGR	
		RA				NJA		AAC	
C7791132		RIFLE, M14-NM				ENGR		ENGR	
NEXT ASSY		USED ON				SUBMITTED		SIZE CODE IDENT NO	
						V.A. LUNKHONEN		C 19205	
APPLICATION						APPROVED		7791135	
						H.F. LYNCH		SCALE UNIT WT. SHEET 1 OF 1	

DRAWING SIZE C 4

3

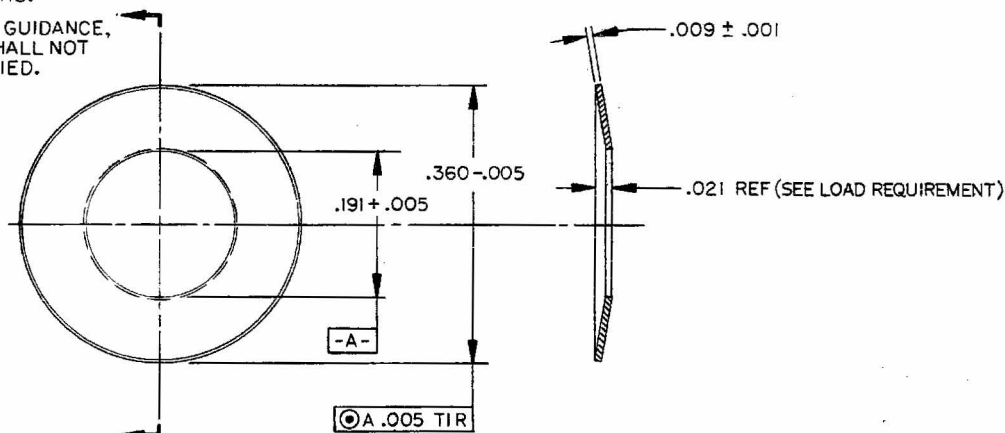
2

1

## NOTES:

1. MIL-W-13855 SHALL APPLY.
2. MATERIAL: STEEL, CMPSN 1075, 1085, 1095 ASTM A684.
3. FINISH 32/ ALL OVER.
4. HEAT TREATMENT: HEAT AT 1500° TO 1550°F. OIL QUENCH. TEMPER 45 MIN AT HEAT TO HARDNESS SPECIFIED.
5. HARDNESS: DIAMOND PYRAMID HARDNESS 424-498, 10KG.
6. FINAL PROTECTIVE FINISH: FINISH 3.3.1 OF MIL-STD-171 WITH FED SPEC VV-L-800 SUPPLEMENTARY OIL TREATMENT.
7. ALL EDGES SHALL BE FREE OF BURRS.
8. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
J	REDRAWN WITH CHANGE NOR W650060/860613 (ECP W652066/861215)	881102	ORDVZ



MAX OPERATING HEIGHT — .018  
LOAD AT MAX OPERATING HEIGHT — 7 LBS ± 2 LBS

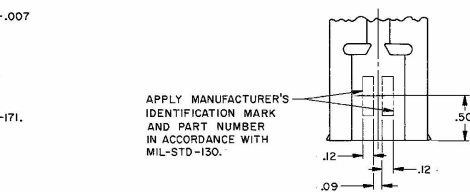
CURRENT DESIGN ACTIVITY CAGE CODE 19200  
U.S. ARMY  
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER  
PICATINNY ARSENAL, NEW JERSEY 07806-5000

PART NO. 7791136

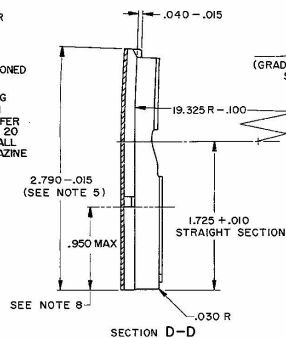
		MECHANICAL PROPERTIES		DO NOT SCALE DRAWING		ORIGINAL DATE OF DRAWING		SPRINGFIELD ARMOY, SPRINGFIELD 1, MASS.	
				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		15 DEC 61			
		YP		TOLERANCES ON DECIMALS *		DRAFTSMAN		CHECKER	
		TS		FRACTIONS * ANGLES *		DSK		RAH	
		EL2		THIRD ANGLE PROJECTION		ENGR		ENGR	
		RA				NJA		AAC	
C7791133		RIFLE M14-NM				ENGR		ENGR	
NEXT ASSY		USED ON				SUBMITTED		SIZE CODE IDENT NO.	
APPLICATION						V.A. LUNKHONEN		C 19205	
						APPROVED		7791136	
						H.F. LYNCH		SCALE 10/1 UNIT WT. SHEET 1 OF 1	

# NOTES:

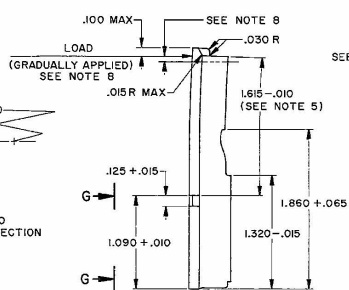
1. FINISH  $\sqrt{125}$  ALL OVER.
2. ALL EDGES SHALL BE BROKEN  $.005R \pm .007$  UNLESS OTHERWISE SPECIFIED AND SHALL BE FREE FROM BURRS.
3. MATERIAL:  
STEEL, COLD ROLLED, NO. 4 TEMPER,  
SPEC QQ-S-698.
4. FINAL PROTECTIVE FINISH:  
FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.
5. DIMENSION BEFORE BENDING.
6. TRANSITION BETWEEN FILLET RADII SHALL BE SMOOTH AND CONTINUOUS.
7. THESE DIMENSIONS SHALL APPLY AT PLANE ①.
8. FILLER SHALL BE CAPABLE OF WITHSTANDING A LOAD OF 45 LBS MINIMUM WITHOUT EVIDENCE OF CRACKS OR BREAKAGE. DEFORMATION OF  $.005$  MAX IS PERMISSIBLE. AMOUNT OF DEFORMATION SHALL BE MEASURED  $.06$  BELOW POINT OF LOAD. SUPPORT OF FILLER FOR THIS TEST SHALL NOT EXCEED LIMIT (.950 MAX) SPECIFIED ON SECTION "D-D".
9. FILLER SHALL BE CAPABLE OF BEING POSITIONED AND RETAINED ON MAGAZINE 7790183.
10. FILLER SHALL BE CAPABLE OF POSITIONING AND HOLDING A LOADED 5 ROUND 7.62 MM CARTRIDGE CLIP SO AS TO PERMIT TRANSFER OF THE CARTRIDGES FROM THE CLIP TO A 20 ROUND M4 MAGAZINE. THIS SEQUENCE SHALL BE ABLE TO BE REPEATED UNTIL THE MAGAZINE IS LOADED TO CAPACITY (20 ROUNDS).
11. MIL-W-13855 APPLIES.



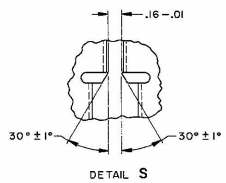
VIEW G-G



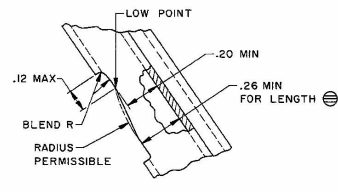
SECTION D-D



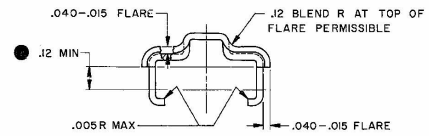
VIEW T-T



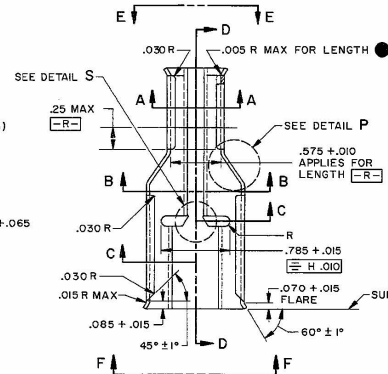
DETAIL S



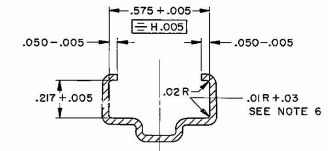
VIEW T-T



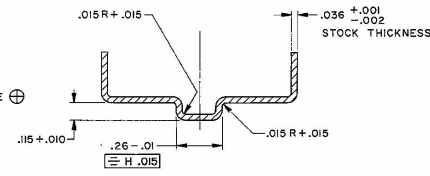
END VIEW E-E



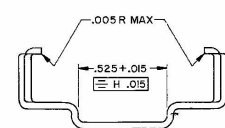
END VIEW F-F



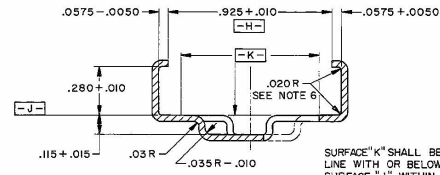
SECTION A-A



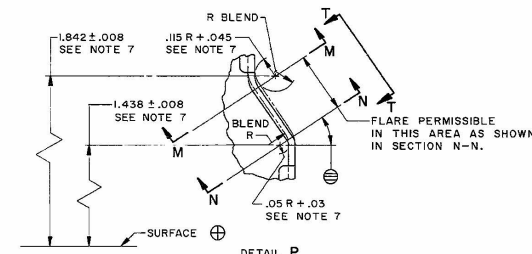
SECTION B-B



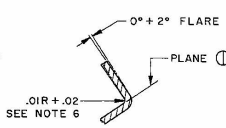
END VIEW F-F



SECTION C-C



SECTION M-M



SECTION N-N

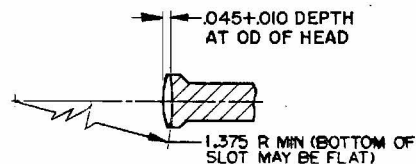
REV	DATE	DESCRIPTION	APPROVED
1	10 SEP 88	REDESIGNED W/CHANGES	W. H. S.
2	10 SEP 88	SEE ED HING REEKS	W. H. S.
3	10 SEP 88	SEE ED HING REEKS	W. H. S.
4	10 SEP 88	SEE ED HING REEKS	W. H. S.

FOR LIST OF SPECS, SEE ENGINEERING SPECS LIST-7791154

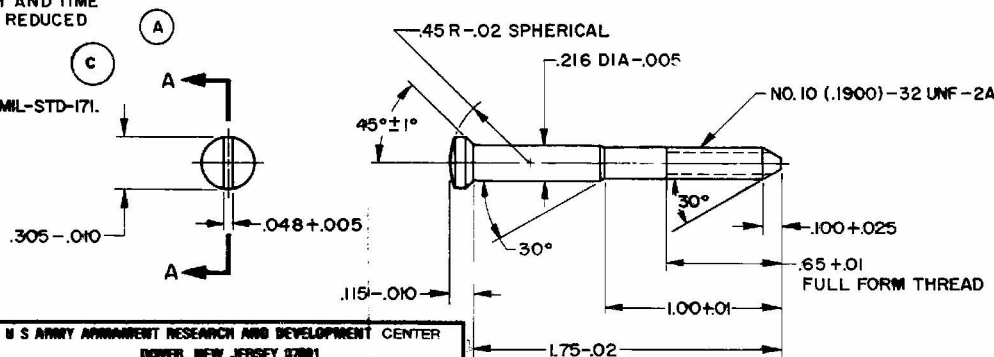
MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE 7 FEB 81		PART NO. 7791154	
1P		TOLERANCES UNLESS OTHERWISE SPECIFIED		DESIGNED BY	W. H. S.	DEPT OF THE ARMY	
1S		ANGLES	30° ± 1°	ENGINEERED BY	W. H. S.	US ARMY WEAPONS COMMAND ROCK ISLAND, IL 61201	
1L		MATERIAL	SEE NOTE 3	TESTED BY	W. H. S.	FILLER, MAGAZINE, 7.62-MM, 5 ROUND	
1A	AIR2002927	HEAT TREATMENT		SUBMITTED BY	W. H. S.	DWG. SIZE (CODE) SHEET NO.	
1H	M14 NM M4AL	FINAL PROTECTIVE FINISH	SEE NOTE 4	APPROVED BY	W. H. S.	F 19204 7791154	
1N	NEXT ASSY	USED WITH		SCALE 2/1	1 OF 1	SHEET 1 OF 1	

NOTES:

1. FINISH 125/
2. ALL EDGES SHALL BE BROKEN .005+.010 UNLESS OTHERWISE SPECIFIED.
3. HEAT TREATMENT: CARBURIZE AT 1550° TO 1600°F FROM .003 TO .005 DEPTH. OIL QUENCH. TEMPER 20 MIN AT 350°. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
4. MIL-W-13855 APPLIES.
5. FINISH 5.3.1.2. OR 5.3.2.2 OF MIL-STD-171.
6. ANSI Y14.5 APPLIES



SECTION A-A



U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DUNEL, NEW JERSEY 07001

CURRENT

FSCM NO.  
19200

PART NO. 7791267

MECHANICAL PROPERTIES

YP

TS

EL2

RA

BH

FILED  
SEE NOTE 4

F11686428 RIFLE, M14

SEE ENGINEERING RECORDS

NEXT ASSY USED ON

APPLICATION

APPLY PART NO.

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES

TOLERANCES ON DECIMALS ±

FRACTIONS ± ANGLES ± 5°

MATERIAL: STEEL, SPEC ASTM-

A108: 1018, 1020 OR STEEL

COMP 1117, SPEC ASTM A108.

HEAT TREATMENT

SEE NOTE 3

FINAL PROTECTIVE FINISH

SEE NOTE 5

ORIGINAL DATE  
OF DRAWING 16 JUL 65

DRAFTSMAN ECH CHECKER J.H.

TRACER RUP CHECKER JP

ENGINEER C.T. Gaudin ENGINEER J.L. Sade

SUBMITTED

APPROVED R.S. Henry

APPROVED W.D. Luckman

SPRINGFIELD ARMOY,  
SPRINGFIELD, MA

SCREW, MACHINE, SLOTTED

DWG SIZE CODE IDENT NO.

B 19205

7791267

SCALE 2/1

UNIT WT

REF SAB-27963

PDC

WEI FORM NO. 1176-1  
20 MAR 64 REV.

REVISIONS

LTR	DESCRIPTION	DATE	APPROVED
A	(1-3) SEE EO SA 28757	17 DEC 65	<i>[Signature]</i>
B	(1-3) SEE EO 82048	11 MAR 68	<i>[Signature]</i>
C	SEE ERR HQR 20619	26 MAY 72	<i>[Signature]</i>
D	NOR WBS2022/79-03-26	79-04-01	SA R. L. L.
E	NOR WIS0034/810915	860811	MR J. J. P.
F	ERR 2921176D (ECP W250056/821116)	890911	DEF. C. T. E. M.



8

7

6

5

4

3

2

1

## NOTES:

1. MATERIAL: COMPONENT SHALL CONFORM TO SPEC MIL-P-9400. THE ORDER OF LAMINATION FROM EXTERIOR TO INTERIOR SHALL BE:

a. MAT, SURFACING-FIBROUS GLASS SURFACING MAT 0.010 INCH TO 0.030 INCH THICK WITH A POLYESTER BINDER.

b. GLASS MAT CONFORMING TO MIL-M-43248, TYPE I, CLASS I, GRADE A DRY TENSILE STRENGTH 45 POUNDS WET TENSILE STRENGTH 25 POUNDS NOMINAL WEIGHT 3 OZ/SQ. FT.

c. RESIN, AS REQUIRED, MIL-P-43038, UP TO 35 PARTS OF BULK FILLER (SILICA OR ALUMINA) PER 100 PARTS OF RESIN MAY BE USED IN COMPOUNDING RESIN FOR MOLDING.

d. CLOTH, SPEC MIL-C-9084, TYPE III A, 164-150, 2 LAYERS.

2.

H

3. DRAFT ANGLES WITHIN TOLERANCE ZONES PERMISSIBLE.

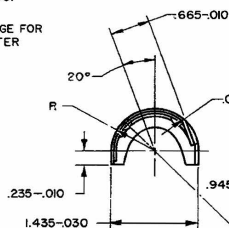
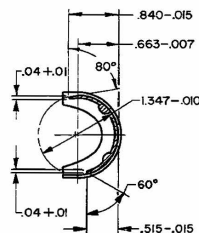
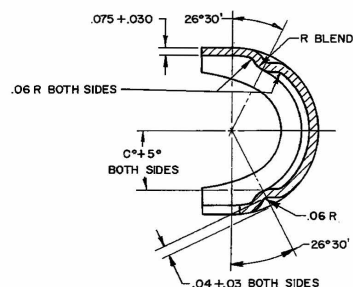
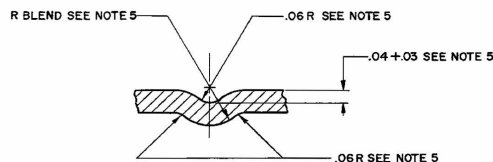
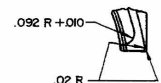
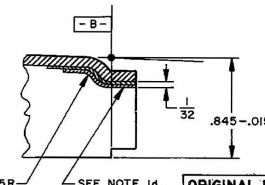
4. COLOR SHALL BE IN ACCORDANCE WITH FED-STD-595 COLOR NO. 30045.

5. THESE DIMENSIONS SHALL APPLY ON THE TOP REINFORCING INDENTATIONS.

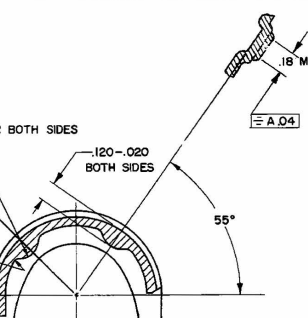
6. HARDNESS SHALL BE BARCOL 50 MIN. AVERAGE FOR FIVE READINGS TAKEN WITHIN 24 HOURS AFTER MOLDING.

7. MIL-W-13855 SHALL APPLY.

SECTION A-A

DETAIL D  
SCALE: 4/1SECTION B-B  
SCALE: 2/1VIEW C  
SCALE: 2/1VIEW F  
SCALE: 2/1

REVISIONS			
LTR	DESCRIPTION	DATE	APPROVED
C	REDRAWN WITH CHANGE, SEE EO SA 29593	2 MAR 66	
D	SEE EO SA 29695	3 OCT 66	
E	(1) SEE EO 82046	11 MAR 68	
F	(1) SEE EO HRD 92078-2	25 JAN 69	
G	(1) SEE EO HRD 92189	2 SEP 69	
H	SEE EO HRD 02107	7 MAY 70	

SECTION E-E  
SCALE: 2/1

ORIGINAL DESIGN ACTIVITY FSCM NO.19205  
CURRENT DESIGN ACTIVITY FSCM NO.19200  
US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

PART NO. 7791285

GUARD, HAND

DWG SIZE

D

SCALE 1/1

UNIT WT

7791285

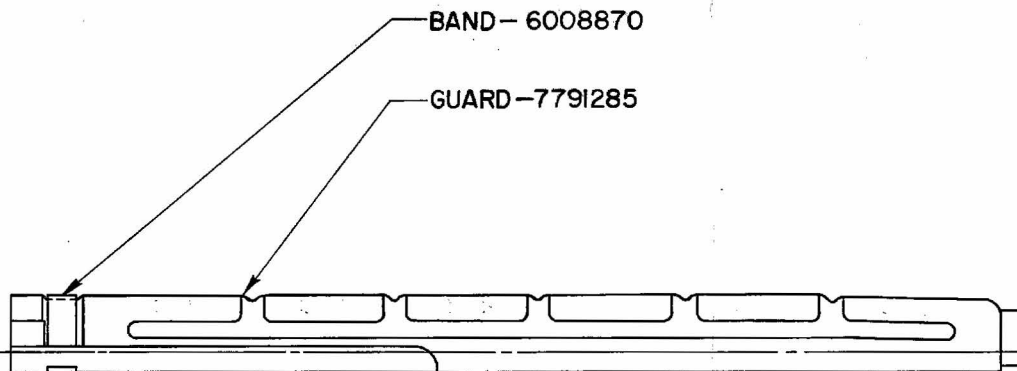
SHEET 1 OF 1

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING	
YP		TOLERANCES ON - DECIMALS = .010		DRAFTSMAN	CHECKER
TS		FRACTIONS = 1/64	ANGLES = 1°	TRACER	CHECKER
EL 2		MATERIAL		ENGINEER	ENGINEER
RA	C7791286	SEE NOTE 1		SUBMITTED	
BH		HEAT TREATMENT		APPROVED	
RH		FINAL PROTECTIVE FINISH		18 OCT 61	
SEE NOTE 6		SEE NOTE 2			

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NOTES: (B1)  
1. MIL-W-13855 SHALL APPLY.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
A	SEE EO SA 29261	18 MAY 66	
B	(1-2) SEE EO 82048	11 MAR 68	
C	(1) SEE EO HRD 92078-2	25 JUN 68	
D	SEE EO HRD 02138	7 FEB 65	
E	NOR W882022/79-03-26	7904-01 SA 0511	
F	NGRWZ52025	84-02-10	84-04-20



C 7791286

ORIGINAL DESIGN ACTIVITY FSCM NO.19205  
CURRENT DESIGN ACTIVITY FSCM NO.19200  
US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

CODE IDENT NO. 19204

PART NO. 7791286

FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 7791286

PHYSICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 18 OCT 61		DEPT OF THE ARMY US ARMY WEAPONS COMMAND ROCK ISLAND, ILL 61208 DWS RDC 7791286 C
TP		TOLERANCES ON DECIMALS		DRAFTSMAN	CHECKER	
TS		ANGLES	FRACTIONS	TRADER	CHECKER	
EL 2	F7267000 RIFLE M14	MATERIAL		ENGINEER	ENGINEER	
RA		HEAT TREATMENT		SUBMITTED		GUARD ASSEMBLY, HAND
RM		DO NOT	APPLY PART NO.	APPROVED BY ORDER OF THE CHIEF OF ORDNANCE		
RH		AS-SPECIFIED		D. A. Lusk		

MECHANICAL PROPERTIES		APPLY PART NO.		REVISIONS			
YP		APPLICATION		LTR	DESCRIPTION	DATE	APPROVED
TS		NEXT ASSY	USED ON	A	(1) SEE ED SA 28757	17 DEC 65	<i>[Signature]</i>
EL2		SEE ENGINEERING RECORDS		B	(1-2) SEE EO 82048	11 MAR 68	<i>[Signature]</i>
RA		F 11686428 RIFLE, M14		C	NOR W8S2022/79-03-26	79-04-01	SAR <i>[Signature]</i>
BH							
RH							

(A)

(BI)

SEE FED. SPEC FF-N-836, NUT, PLAIN, SQUARE, TYPE I, STYLE 3, GRADE C, NO.10 (.1900)-32UNF-2B, FOR DESCRIPTION OF THIS PART EXCEPT AS NOTED BELOW.

FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.

CODE IDENT NO.

19200

US ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND  
DOVER, NEW JERSEY 07801

PART NO. 7791339

(B2)

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 16 JUL 65		<del>DEPT OF THE ARMY</del> <del>ROCK ISLAND ARSENAL</del> <del>ROCK ISLAND, ILL. 61201</del>	
TOLERANCES ON FRACTIONS DECIMALS ANGLES +     +     + -     -     -		DRAFTSMAN <i>[Signature]</i>	CHECKER <i>[Signature]</i>		
MATERIAL		TRACER <i>[Signature]</i>	CHECKER <i>[Signature]</i>		
HEAT TREATMENT		ENGR. <i>[Signature]</i>	ENGR. <i>[Signature]</i>		
FINAL PROTECTIVE FINISH		SUBMITTED <i>[Signature]</i>		NUT, PLAIN, SQUARE	
		APPROVED <i>[Signature]</i>		DWG SIZE A	CODE IDENT NO. <del>19204</del> 7791339
				SCALE NONE	UNIT WT     SHEET   OF



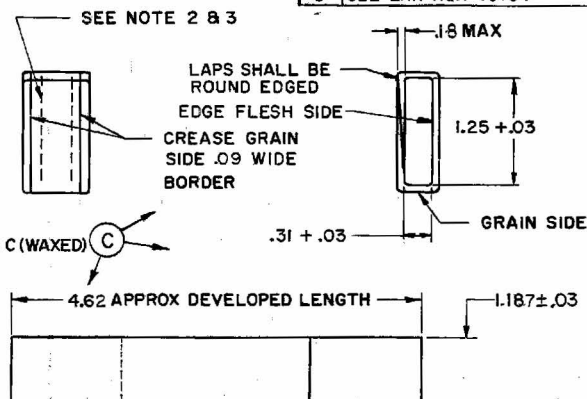
E	SEE NOR 75E0025-0009	3100175	MR
F	NOR W4S2051 / 840824 ECP W9S2014 / 790608 ECPW5S2086 8509091 ECPW5S2069 851223	860121	

B7791349

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
A	SEE EO RIA-14276	7-13-67	<i>L.H. Fuller</i>
B	(1-2) SEE EO RIA-14587	13 JAN 68	<i>P. Hefner</i>
C	(1-3) SEE EO HRD 92086	25 JUN 68	<i>L. J. ...</i>
D	SEE ERR HQR 10754	11 NOV 71	<i>K. W. Adams</i>

## NOTES:

- MATERIAL:  
LEATHER, TYPE III, CLASS I,  
RUSSET, 8/64 THICK,  
SPEC KK-L-271.
- STITCHING: FED. STD NO. 751, STITCH  
TYPE 301, SEAM TYPE LSd-2,  
7 STITCHES PER INCH. STITCHES  
SHALL BE TIGHT AND ENDS OF THREADS  
SHALL BE BACKSTITCHED TO PREVENT  
RAVELING.
- THREAD, POLYESTER, TYPE I, CLASS I, NO. 4, SUBCLASS C (WAXED)  
COLOR TAN, SHADE X, CA 66041, SPEC V-T-285.
- CUT EDGES SHALL BE GUMMED WITH  
GUM TRAGACANTH AND RUBBED TO  
A SMOOTH FINISH.
- MIL-W-13855 APPLIES.



CURRENT DESIGN ACTIVITY FSCM NO. 19205  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

CODE IDENT  
NO. 19204

ORIGINAL FSCM NO. 19205

PART NO. 7791349

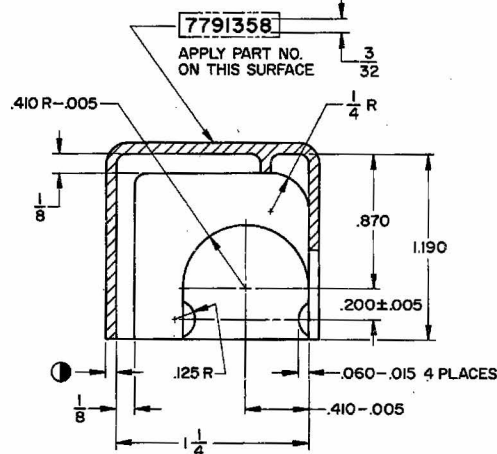
SLING, SMALL		PHYSICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED		ORIGINAL DATE OF DRAWING: 29 JAN 62		DEPT OF THE ARMY ROCK ISLAND ARSENAL ROCK ISLAND, ILL. 61201 7791349 SHEET 1 OF 1	
C7141245	ARMS, M1907	YP		DIMENSIONS ARE IN INCHES TOLERANCES ON FRACTIONS DECIMALS ANGLES ± .02		DRAFTSMAN: <i>DEB</i> CHECKER: TRACER: <i>DEB</i> CHECKER: <i>CRK</i> ENGR: <i>CRK</i> CHECKER: <i>REAR</i> SUBMITTED: <i>DR. ...</i> ORG CORPS			
C7791390	SLING,	TS		MATERIAL SEE NOTE 1 & 2		APPROVED BY ORDER OF THE CHIEF OF ORG: <i>A. J. ...</i> ORG CORPS			
	LEATHER	EL2		HEAT TREATMENT					
NEXT ASSY		USED ON		FINAL PROTECTIVE FINISH SEE NOTE 5		SCALE 1/1		UNIT WT	

KEEPER, STRAP

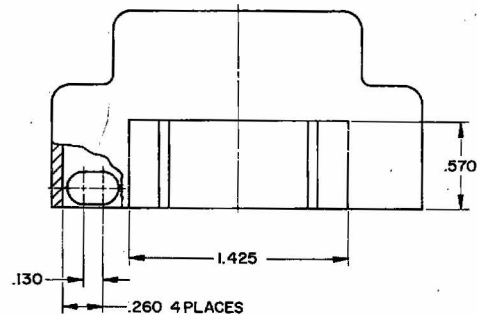
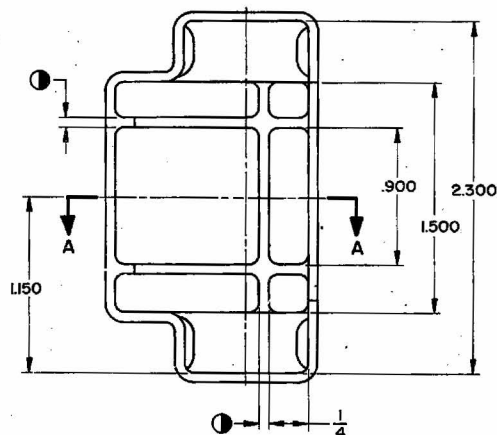
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# NOTES:

1. ALL INSIDE RADII AND FILLETS 1/16R MAX UNLESS OTHERWISE SPECIFIED.
2. MATERIAL: POLYETHYLENE, SPEC-L-P-390 TYPE I, CLASS L GRADE 1 OR 2 (D) COLOR NATURAL FINISH SMOOTH
3. PARTS SHALL BE FREE OF WARP, CRACKS, BLISTERS, UNEVEN SURFACES, FINS, BURRS, AND PROJECTING RIDGES, BUFFING MAY BE EMPLOYED AS NECESSARY.
4. (D) THICKNESS OF MATERIAL .062



SECTION A-A



REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
B	REDRAWN & REVISED SEE EO SA 27456	13 DEC 63	
C	SEE HOP-31608	15 MAY 64	
D		1 FEB 73	

PART NO. 7791358 (D)

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 28 FEB 62		DEPT OF THE ARMY	
YP		TOLERANCES ON DECIMALS ±.010		DRAFTSMAN RSB	CHECKER DJOS	ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
TS		FRACTIONS ± 1/32 ANGLES ±		TRACER 98	CHECKER 491	PROTECTOR, APERTURE ASSEMBLY	
EL 2	D8449427	MATERIAL SEE NOTE 2		ENGINEER [Signature]	ENGINEER [Signature]		
RA	SEE ENGINEERING RECORDS	HEAT TREATMENT		SUBMITTED		CODE IDENT NO. DWG SIZE	
BH	NEXT ASSY USED ON	FINAL PROTECTIVE FINISH		APPROVED [Signature]		00000 C 7791358	
RH	APPLICATION					SCALE 2/1	UNIT WT
	DO PER MIL-STD-130 AS SPECIFIED					SHEET 1 OF 1	PDC

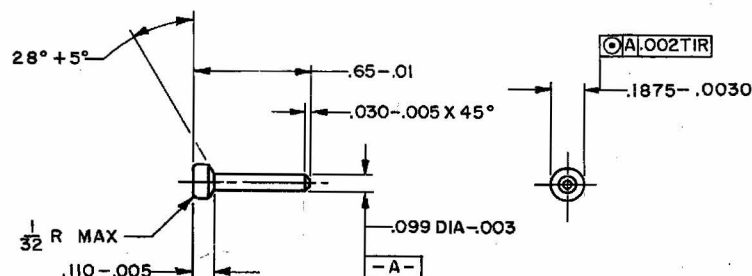
REVISIONS			
S/N	DESCRIPTION	DATE	APPROVAL
A	(1-3) SEE EO SA 29262	18 MAY 96	<i>[Signature]</i>
B	SEE EO 82048	11 MAR 96	<i>[Signature]</i>
C	(1) SEE EO HRD 92078-2	25 JUN 99	<i>[Signature]</i>
D	SEE EO HRD 02138	71 FEB. 25	<i>[Signature]</i>
E	(3) SEE ERR HQR 40681	10 FEB 75	<i>[Signature]</i>
F	NOR W8S2022/79-03-26	79-04-01	<i>[Signature]</i>
G	NORW432051/840824 ECPW552069 / 851223	860121	<i>[Signature]</i>

1. MATERIAL: SPEC ASTM A108 : 1060,  
AUSTENITIC GRAIN SIZE 7 OR FINER.

## 2. FINISH

3. HEAT TREATMENT : HEAT AT 1500° TO 1550°F. OIL QUENCH. TEMPER 20 MIN AT HEAT NOT LESS THAN 700°F. DECARBURIZATION NOT TO EXCEED .001. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.

4. MIL-W-13855 APPLIES.



CURRENT DESIGN ACTIVITY FSCM NO 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

~~CODE IDENT NO 19204~~

ORIGINAL FSCM NO. 19205 PART NO. 7791367

	RIFLE, M14 NM
D7790195	RIFLE, M14
D6528297	30R-M1, MIC & MID
WEAK ASBY	USED ON
APPLICATION	
DO NOT	APPLY PART NO.
END	-AS SPECIFIED

PHYSICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED		
YP		DIMENSIONS ARE IN INCHES TOLERANCES ON		
TS		FRACTIONS	DECIMALS	ANGLES ± 5°
EL2		MATERIAL		
RA		SEE NOTE 1		
BH		HEAT TREATMENT		
RM	D51 TO 56	-SEE NOTE 3		
		FINAL PROTECTIVE FINISH LUB OIL, SPEC VV-L-800		

ORIGINAL DATE OF DRAWING		19 APR 62	
DRAFTSMAN	<i>JEP</i>	CHECKER	<i>EPS</i>
TRACER	<i>JEP</i>	CHECKER	<i>EPS</i>
ENGR	<i>D. R. R.</i>	ENGR	<i>P. H. H.</i>
SUBMITTED			
<i>V. A. L.</i>			
OHD CORPS			
APPROVED BY ORDER OF THE CHIEF			
<i>S. F. L.</i>			
OHD CORPS			

## PIN, TRIGGER

~~DEPT OF THE ARMY~~  
~~ROCK ISLAND ARSENAL~~  
~~ROCK ISLAND, ILL. 61201~~

DWG SIZE	7791367	
B	SHEET	OF

SCALE 2 / 1	UNIT WT
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OWG SIZE	7791417		
D	SHEET	OF	

DD7791417

1c

**B**

**D7791417**

1A

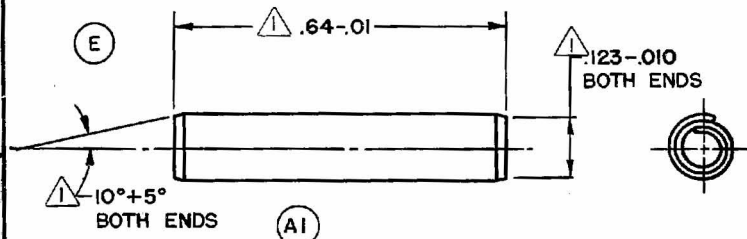
FORM 1181  
APR 54

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PHYSICAL PROPERTIES		DO NOT DO	APPLY PART NO. AS SPECIFIED	REVISIONS			
YP		APPLICATION		SYM	DESCRIPTION	DATE	APPROVAL
TS		NEXT ASSY	USED ON	A	(1-2) SEE EO SA 29262	18 MAY 66	<i>J. J. S.</i>
EL2		C7790196	RIFLE, M14	B	SEE EO 82048	11 MAR 68	<i>P. Helander</i>
RA			RIFLE, M14	C	(1) SEE EO HRD 92078-2	25 JUN 68	<i>C. J. F.</i>
BI			RIFLE, M14	D	SEE EO HRD 02138	71 FEB 75	<i>C. J. F.</i>
RM			RIFLE, M21	E	(2) SEE ERR HQR 40681	10 FEB 75	<i>C. J. F.</i>
				F	NOR W8S2022/79-03-26	79-04-01	SA R. A. L.

# NOTES

1. SAME AS MS 51923-249,  $\Delta$  ALTER AS SHOWN.
2. MIL-W-13855 SHALL APPLY.



US ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND  
DOVER, NEW JERSEY 07801

CODE IDENT NO.

19200

ALTERED ITEM DRAWING

USED IN HOUSING  
ASSEMBLY, TRIGGER

~~CODE IDENT NO. 19204~~

PART NO. 7791418

UNLESS OTHERWISE SPECIFIED	ORIGINAL DATE OF DRAWING	22 OCT 62
DIMENSIONS ARE IN INCHES	DRAWN BY	CHECKER
TOLERANCES ON FRACTIONS DECIMALS ANGLES	TRACED BY	CHECKER
MATERIAL	ENGINEER	CHECKER
HEAT TREATMENT	SUBMITTED	
FINAL PROTECTIVE FINISH	APPROVED BY DIRECTOR OF THE CHIEF OF ORDNANCE	

PIN, SPRING,  
TUBULAR,  
COILED

DEPT OF THE ARMY  
ENGINEERING AND RESEARCH  
ENGINEERING AND RESEARCH  
ENGINEERING AND RESEARCH

SCALE 5/1

UNIT WT

OWN SIZE

A

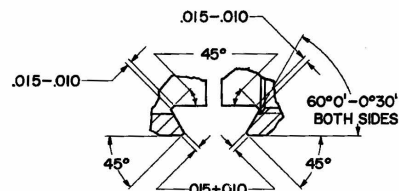
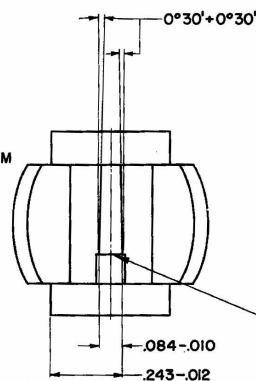
7791418

SHEET 1 OF 1

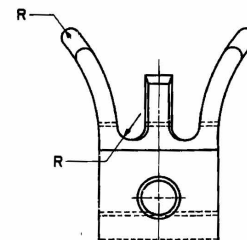
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## NOTES:

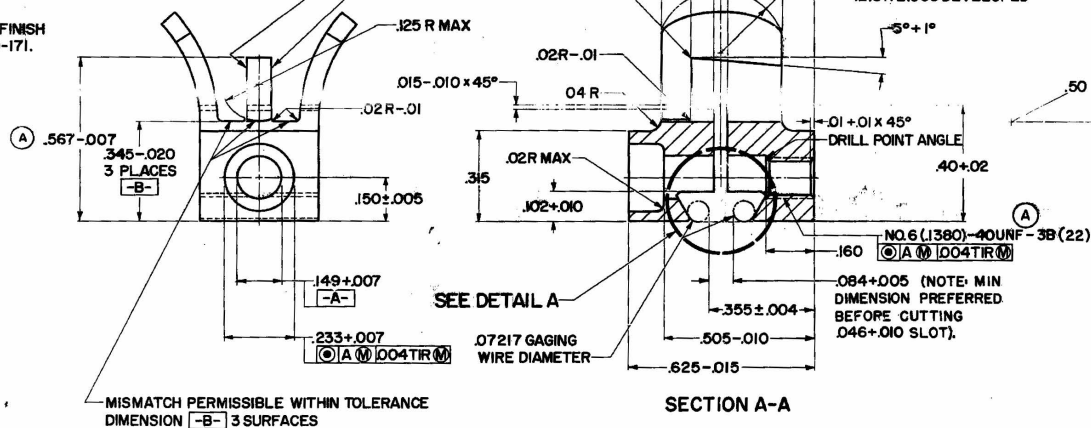
1. FINISH 125/.
2. ALL EDGES SHALL BE BROKEN .005+.010 UNLESS OTHERWISE SPECIFIED.
3. EDGES TO BE SHARP TO .005R MAX AND FREE OF BURRS.
4. MATERIAL:
  - A. FOR WROUGHT MATERIAL: STEEL, SPEC ASTM A304, A322, A331:8640, 8740 OR 4150.
  - B. FOR PRECISION CASTING: STEEL, MIL-S-22141:IC-4140 EXCEPT; CARBON 43 TO 53 PERCENT TENSILE TEST SHALL NOT APPLY. INSPECTION SHALL BE IN ACCORDANCE WITH MIL-C-6021. CLASS 2A, GRADE C.
5. HEAT TREATMENT: (FOR MATERIALS A AND B) HEAT AT 1550° TO 1575° F. FOR 30 MINUTES. QUENCH IN CIRCULATING OIL. TEMPER 30 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
6. FINAL PROTECTIVE FINISH: FINISH 53.1.2 OR 53.2.2 OF MIL-STD-171.



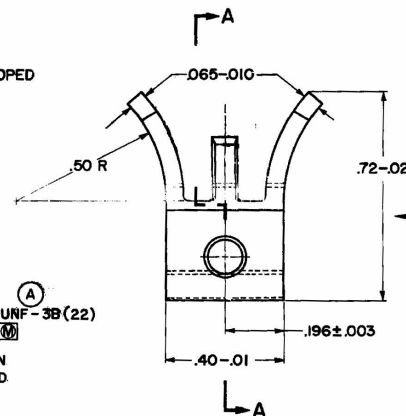
DETAIL A



ALTERNATIVE DESIGN



SECTION A-A



(1) RT SEE NOTE 4B

D7791445

CURRENT DESIGN ACTIVITY CASE CODE 19200  
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER  
PACIFIC AIR FORCE, HAWAII

PART NO. 7791445

SPRINGFIELD ARMOY, SPRINGFIELD, MA

SIGHT, FRONT


CODE IDENT NO 19205

D7791445

SCALE 5/1 UNIT WT RMH

PHYSICAL PROPERTIES	UNLESS OTHERWISE SPECIFIED	ORIGINAL DATE OF DRAWING
VP	DIMENSIONS ARE IN INCHES	22 OCT 62
TS	TOLERANCES ON FRACTIONS	DECIMALS
ELZ	± 1/64 ± .01 ± .15	
RA	SEE NOTE 4	
MA	HEAT TREATMENT	
SH	SEE NOTE 5	
RM	FINAL PROTECTIVE FINISH	
RM	SEE NOTE 6	

12

1. FINISH 125 / EXCEPT AS NOTED.
2. ALL CORNERS SHALL BE ROUNDED  
R .005 R4.0025 UNLESS OTHERWISE SPECIFIED.
3. HEAT TREATMENT: NORMALIZE BEFORE  
MACHINING. HEAT TO 1525° TO 1550° F.  
OIL QUENCH. TEMPER 20 MINUTES AT HEAT TO  
HARDNESS SPECIFIED. -  
FOR QUANTITIES EXCEPT THAT TEMPERING TIME  
SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
4. REMOVAL OR PARTIAL REMOVAL OF PROTECTIVE  
FINISH ON .2725 DIA+.0020 AND ON THREADED IS  
PERMISSIBLE.
5. THREAD DIMENSIONS AND DESIGNATIONS SHALL BE INTERPRETED  
IN ACCORDANCE WITH HANDBOOK HX AND MIL-STD-107, RESPECTIVELY.
6. DIMENSIONS LABELED  SHALL APPLY TO A THEORETICAL SHARP  
TAPER.
7. FINAL PROTECTIVE FINISH: MIL-S-31212 OR S-312-2 OF MIL-STD-171.  
8. MIL-P-3855 SHALL APPLY.
9. MATERIAL: A - FOR INQUIRY MATERIAL: STEEL, ASTM A36, 1141,  
1045 FOR PRECISION CASTING: STEEL MIL-S-29124 COM 1040
10. CLASSIFICATION AND INSPECTION OF INVESTMENT CASTINGS  
TO BE IN ACCORDANCE WITH CLASS 4, GRADE B, MIL STD 2175

CENTER LINE OF APERTURE GROOVE  
SHALL BE HELD TO  $90^{\circ}0' \pm 0^{\circ}15'$   
WITH CENTER LINE OF PINION  
HOLE AND THREAD.



TABLE 4/

MECHANICAL PROPERTIES		DO NOT SCALE GRATING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DESIGN <b>18 NOV 63</b>		PART NO. <b>7791571</b>	
TP	TP	TOLERANCES ON DECIMALS FRACTIONS 2/164 INCHES = P		DESIGN TESTER <b>DSK</b>	CHECKER <b>EPS</b>	<b>BASE, REAR SIGHT</b>	
TR	TR	THIRD ANGLE PROJECTION		DESIGN AUTHORITY <b>MJA</b>	DESIGN AUTHORITY <b>AAC</b>		
TS	TS			DESIGN <b>SUBMITTED</b>	DESIGN <b>R.S. HENRY</b>		
BR	BR			APPROVED <b>V.A.L. HONKONEN</b>		SIZE <b>F</b>	QUANTITY <b>12026</b>
NEXT ASSEMBLY USED ON		REV <b>C45-50</b>				SCALE <b>2 1/2" = 1"</b>	QUANTITY <b>106</b>
APPLICATION							

CURRENT DESIGN ACTIVITY CAGE CODE 19200  
U.S. ARMY  
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENT  
PICATINNY ARSENAL, NEW JERSEY 07806-5000

PART NO. 7791571

SPRINGFIELD ARMOY, SPRINGFIELD 1, MASS.

BASE, REAR SIGHT

SIZE	CODE IDENT NO.	
F	19205	7791571

SCALE 2/1	UNIT WT. .06	SHEET 10
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- NOTES:
1. FINISH  $12\frac{3}{4}$  EXCEPT AS NOTED.
  2. ALL EDGES SHALL BE BROKEN .005+.010 UNLESS OTHERWISE SPECIFIED.
  3. STEEL, CMPSN 8645, 08874Q SPEC ASTM A304, A322, A331, GRAIN SIZE 7 OR FINER.

4. HEAT TREATMENT: HEAT TO 1500° TO 1550°F. OIL QUENCH. TEMPER 1 HOUR AT HEAT TO HARDNESS SPECIFIED. NO DECARBURIZATION PERMISSIBLE. AFTER HEAT TREATMENT SHOT PEEN .013A-.015A INTENSITY WITH NO.170 SHOT AT THE .020+.005 RADIUS AT JUNCTION STEM AND BODY. SEE SPEC MIL-S-13165 HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.

5. [A] ALONG A RADIUS CONCENTRIC WITH [B].

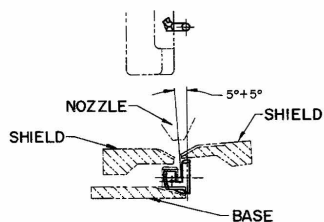
6. [C] LOCATION OF 70° CONE CENTER.

7. FINISH REQUIREMENTS SPECIFIED FOR THESE TWO SURFACES SHALL APPLY BEFORE SHOT PEENING. SEE SECTION C-C.
8. [D] SHALL APPLY WITHIN [E] AND ABOVE DATUM LINE [F]. [D] IS DEPICTED AT AN EXTREME MISMATCH CONDITION TO ILLUSTRATE ITS TERMINAL RADIUS. A MISMATCH IN THE OPPOSITE DIRECTION IS ALSO PERMISSIBLE.

9. .157 DATUM GAGE LOCATION [P] & DATUM LINE [K] WHICH IS TANGENT TO [L] PRESCRIBE ORIENTATION OF COMPONENT SUCH THAT THE LOCATION OF OTHER DIMENSIONAL FEATURES IS ESTABLISHED (SEE ZONE E-6).
10. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OF MIL-STD-171.

11. MIL-W-13895 SHALL APPLY.

THESE EDGES, ON BOTH SIDES, SHALL BE BROKEN .005R+.010 AND SHALL BE SMOOTH, FREE OF BURRS AND TOOL MARKS. (TO PREVENT START OF A FRACTURE)



VIEW OF SHOT PEENING .020 R+.005 AFTER HEAT TREATMENT

VIEW D-D

PARTIAL SECTION C-C

THIS EDGE SHALL BE BROKEN .005 R+.010, FLUSH OR BELOW SURFACE [J] AND SHALL BE BLENDED INTO THE .065R+.005. (SEE PARTIAL SECTION C-C)

EXTERIOR CORNERS AND EDGES SHALL BE BROKEN .005 R+.015 AND SHALL BE SMOOTH AND FREE FROM BURRS

SECTION A-A

ORIGINAL DESIGN ACTIVITY FROM NO. 19203  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

PART NO. 7791578

EXTRACTOR

7791578

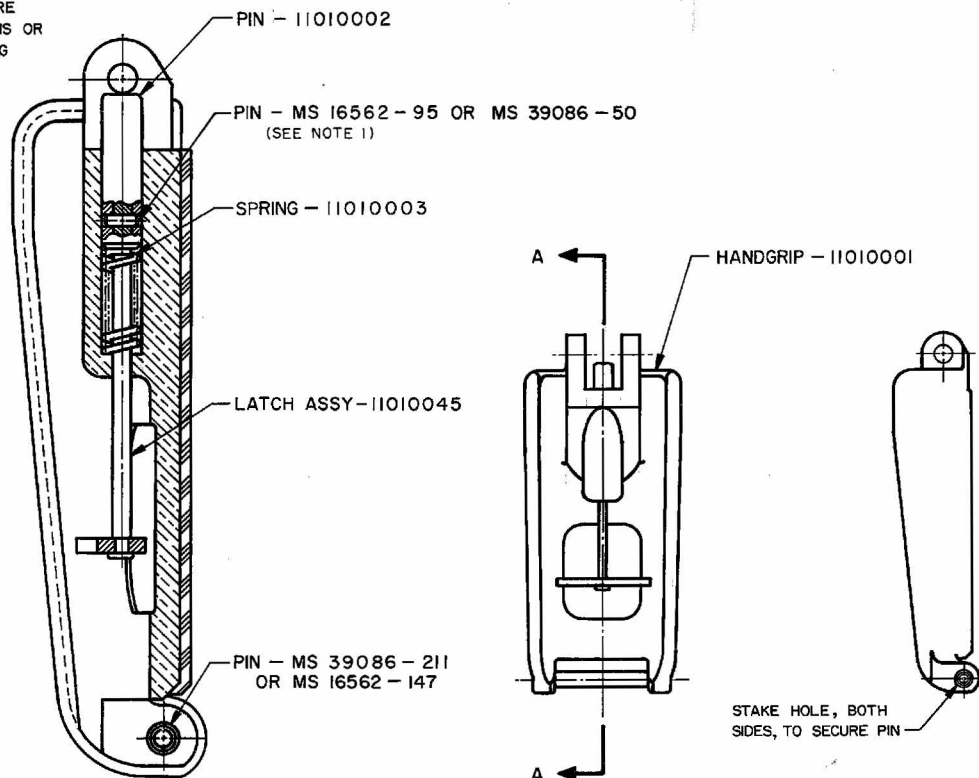
MECHANICAL PROPERTIES		RIFLE, M4-M14		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING		11 MAR 63	
VP	C7790187	RIFLE, M14		TOLERANCES ON DECIMALS		DRAWN	7791		
TS	D5548023	.308 WIN, MIC		FRACTIONS		CHECKED	7791		
EL 2		B. MID		ANGLES		THICK	6PS		
PA									
SH									
RH	C 40-43								
APPLICATION		HEAT TREATMENT		SEE NOTE 4		APPROVED BY ORDER OF THE		CHIEF OF DIVISION	
DO NOT APPLY PART NO		FINAL PROTECTIVE FINISH		SEE NOTE 10		APPROVED BY ORDER OF THE		CHIEF OF DIVISION	
AS-SPECIFIED						SCALE 10/1		UNIT WT A	

REV	DESCRIPTION	DATE	APPROVAL
A	(1) SEE EQ 542895	24 NOV 62	
B	SEE EQ 542895	11 MAR 63	
C	(1) SEE EQ 542895-2	25 APR 63	
D	SEE EQ 542895	THREE 63	
E	(2) SEE ERR NOR 40681	NOV 75	
F	NOR WSS202/79-03-18	79-04-05	
G	NOR WSS2034/85-05-17	85-10-03	
H	NOR W452051/840824 (ECP WSS2069 / 851223)	860121	

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# NOTES:

- I. PIN 11010002 SHALL BE STAKED AT BOTH ENDS OF HOLE TO SECURE SPRING PIN. ANY PROJECTIONS OR BURRS RESULTING FROM STAKING SHALL BE REMOVED.



SECTION A-A  
SCALE: 2/1

FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 7791672

PART NO. 7791672

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 23 OCT 63		SPRINGFIELD ARMOY U. S. ARMY WEAPONS COMMAND	
YP		B 11010044	RIFLE, M14E2	TOLERANCES ON DECIMALS ±		SPRINGFIELD 1, MASS.	U. S. ARMY MATERIEL COMMAND
TS				FRACTIONS ±			
EL 2		SEE ENGINEERING RECORDS		ANGLES ±			
RA				MATERIAL			
BH		NEXT ASSY USED ON		HEAT TREATMENT			
RH		APPLICATION		FINAL PROTECTIVE FINISH			
		DO NOT APPLY PART NO					
		AS SPECIFIED					

DRAFTSMAN  
 CHECKER  
 ENGINEER  
 SUBMITTED  
 APPROVED  
 19205 C 7791672

HANDGRIP SUBASSEMBLY  
 CODE IDENT NO DWG SIZE  
 19205 C 7791672  
 SCALE 1/1 UNIT WT SHEET 1 OF 1

NOTES:

- 3 MATERIAL: PLATE: STEEL, SHEET ASTM  
A109 C/P QUARTER-HARD NO. 3, TEMPER.

PAD: SYNTHETIC RUBBER, SPEC MIL-R-3065 AND MIL-STD-417, CLASS SC, GRADE 515, SUFFIXES A1, B1, C1, F2, K1, Z1, Z2.

**SPECIAL REQUIREMENTS:**

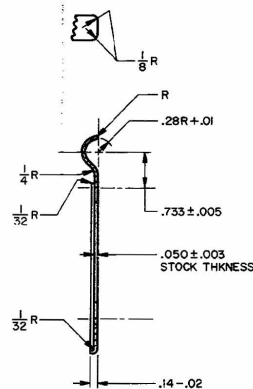
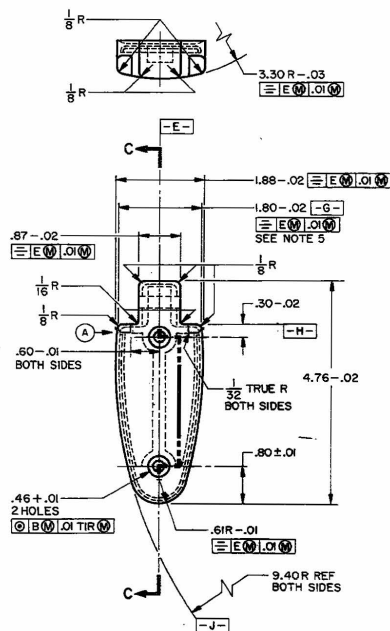
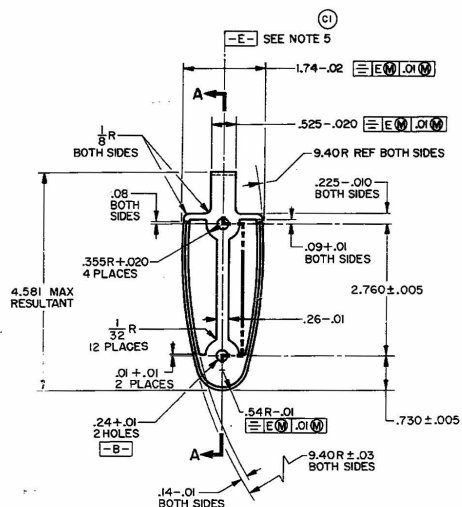
21: CHANGE TENSILE STRENGTH AFTER 30 DAY EXPOSURE OVER WATER AT  $158 \pm 2^\circ \text{F}$  SHALL BE  $-30\%$  MAX. THREE STANDARD ASTM D412 DUMBBELL SPECIMENS SHALL BE SUSPENDED IN A QUART JAR CONTAINING APPROXIMATELY 150 CC DISTILLED WATER. THE SCREW CAP CLOSED JAR SHALL BE PLACED IN AN AIR OVEN AT  $158 \pm 2^\circ \text{F}$  FOR THIRTY DAYS. DISTILLED WATER SHOULD BE ADDED AS REQUIRED TO AVOID HAVING THE JAR GO DRY. AFTER EXPOSURE, THE SPECIMENS SHALL BE WIPED DRY AND TESTED PER ASTM D412. THE AVERAGE OF THE THREE VALUES SHALL BE USED TO DETERMINE COMPLIANCE TO THE REQUIREMENT.

CONFIDENCE TO THE REQUIREMENT.  
Z2: NO CRACKS SHALL BE VISIBLE TO THE NAKED EYE AFTER 30 DAYS EXPOSURE IN A RELATIVE HUMIDITY CABINET IN WHICH THE CIRCULATING AIR IS CONTROLLED TO 100° ± 1° F AND 90 ± 2% RELATIVE HUMIDITY. DUPLICATE BENT LOOP SPECIMENS, ASTM D518 SHALL BE USED. CRACKS IN EITHER SPECIMEN SHALL CONSTITUTE FAILURE. FINISH: LUSTERLESS FINISH TO BE OBTAINED BY SUITABLE GRIT OR SANDBLASTED MOLD.

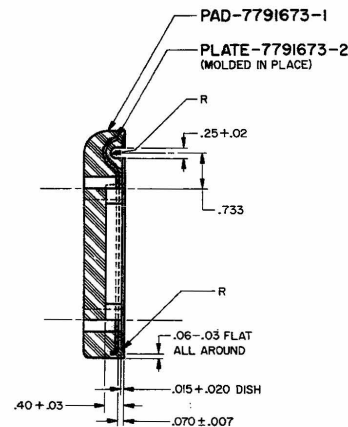
4. DIM ☐ -G- SMALL APPLY WHERE SURFACE ☐ -H-  
AND RADIUS ☐ -J- INTERSECT.

5.  $\boxed{-E-}$  IS ESTABLISHED BY 2 HOLES  $\boxed{-B-}$ .

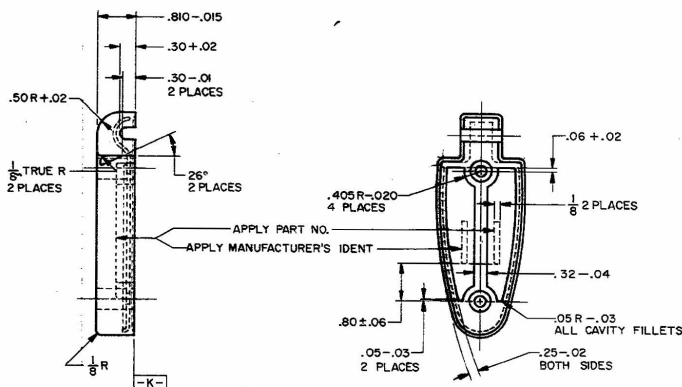
6. MIL-W-13855 APPLIES.



SECTION A-A



SECTION C-C



MECHANICAL PROPERTIES	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING	23
TP	FIG 060526	RIFLE, M16E2	TOLERANCES ON DECIMALS = .01	
CL 1			FRAC = 1/64 ANGLES = 3°	
CL 2	SEE ENGINEERING RECORDS	SEE NOTE 3	TRACTION	CHECKED
RA	NEXT APT. VIDEO ON	HEAT TREATMENT	ENGINEER	10/10/74
	APPLICATION		SUBMITTED	
RH	Q80-880	APPLY PART NO	APPROVED	
SEE NOTE 3	PER MIL - STD - 150	AS SPECIFIED	FINAL PROTECTIVE FINISH	R. S. Harris

ORIGINAL DESIGN ACTIVITY FSCM NO.19205  
CURRENT DESIGN ACTIVITY FSCM NO.19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

2) PART NO. 7791673  
DEPT OF THE ARMY ROCK ISLAND ARSENAL  
ROCK ISLAND, ILL 61201.

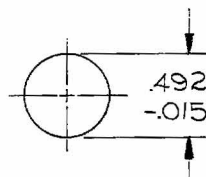
PAD, SHOULDER, RECOIL

CODE IDENT NO.	DWG SIZE	
19204	F	7791673



NOTE:

1. SYNTHETIC RUBBER,  
COMP SC515A, B, C, F<sub>2</sub>, K<sub>1</sub>,  
SPEC MIL-R-3065.
2. FINISH: LUSTERLESS,  
COLOR: FED-STD-595,  
BLACK 37038 THRU 37056.



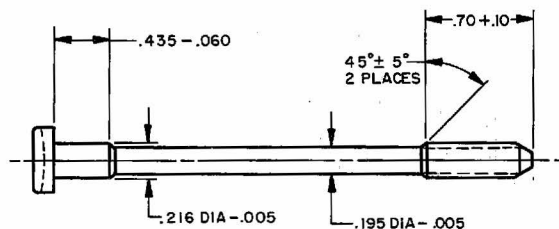
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		B	REPLACES REV A W/CHANGE SEE EO RIA-14175.	5.10.67	gja

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING SEP 23, 1963		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP		TOLERANCES ON	DECIMALS	DRAFTSMAN	CHECKER	PLUG, RECOIL PAD	
TS		ANGLES ±	XX ±	H.M.F.	W.H.S.		
EL 2		MATERIAL	XXX ±	W.H.S.	C.G.		
RA		SEE NOTE 1		SUBMITTED		DWG SIZE	CODE IDENT NO.
BH		HEAT TREATMENT		A.A. COLE		B	19204
RH		NEXT ASSY. USED ON		APPROVED		7791674	
APPLICATION		FINAL PROTECTIVE FINISH		V.A. LUUKKONEN		SCALE 2/1	UNIT WT
						SHEET	OF

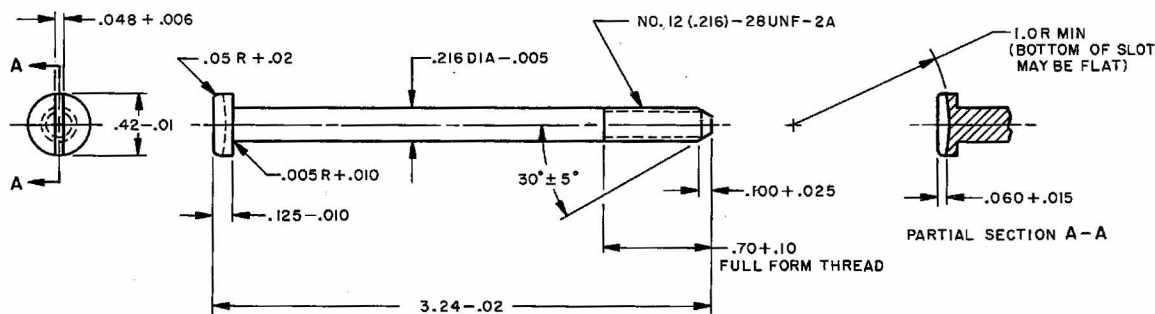
SWER! FORM 40B. 1 MAR 67

NOTES:

1. FINISH 125/
2. MATERIAL: STEEL, FED. SPEC QQ-S-634: (A1)  
1018 THRU 1020 OR FED. SPEC QQ-S-637: 1117.
3. HEAT TREATMENT: CARBURIZE AT 1550° TO 1600°F TO CASE DEPTH .003 TO .005. OIL QUENCH. TEMPER 20 MINUTES AT 350°F. HARDNESS: FILE HARD. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TEMPERING TIME AND TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED. THE USE OF STRAIGHT CYANIDE BATH OR CARBO-NITRIDING PROCESSES SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF THE CONTRACTING OFFICER.



ALTERNATIVE DESIGN



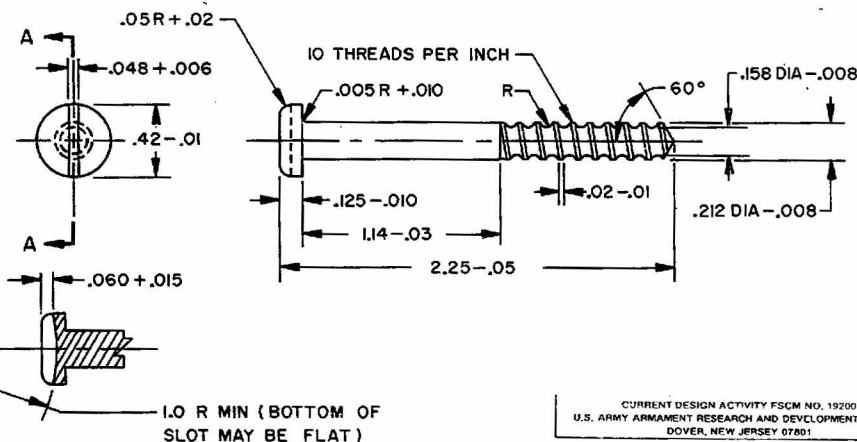
REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
A	(1-3) SEE EO SA29263	18 MAY 66	R. J. Cole

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 23 SEP 63		SPRINGFIELD ARMOY U. S. ARMY WEAPONS COMMAND	
YP	F11686528	RIFLE, M14E2	TOLERANCES ON DECIMALS ±	DRAFTSMAN	CHECKER	SCREW, MACHINE, PAN, HEAD, SLOTTED	
TS			FRACTIONS ±	TRACER	CHECKER		
EL 2	SEE ENGINEERING RECORDS		ANGLES ±	ENGINEER	ENGINEER	7791676	
RA	NEXT ASSY USED ON APPLICATION		SEE NOTE 2	SUBMITTED	APPROVED		
BH	DO NOT APPLY PART NO		HEAT TREATMENT SEE NOTE 3			19205 C	
RH	AS SPECIFIED		FINAL PROTECTIVE FINISH FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171			SCALE 2/1 UNIT WT SHEET 1 OF 1	

NOTES:

1. FINISH 125/
2. MATERIAL: STEEL, CARBON, 1017, 1018, 1020, ASTM A108.
3. HEAT TREATMENT: CARBURIZE AT 1550° TO 1600° F TO CASE DEPTH .003 TO .005. OIL QUENCH. TEMPER 20 MINUTES AT 350° F. HARDNESS: FILE HARD. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TEMPERING TIME AND TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
4. SPEC MIL-W-13855 APPLIES.

(A1)



REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
A	(1-2) SEE EO SA 29263	18 MAY 66	MR
B	NOR W452051 / 840824	860121	MR
C	NOR G253018 / 920224	920325	MR

PARTIAL SECTION A-A

(A2)

DISTRIBUTION STATEMENT A  
APPROVED FOR PUBLIC RELEASE. DISTRIBUTION IS UNLIMITED.

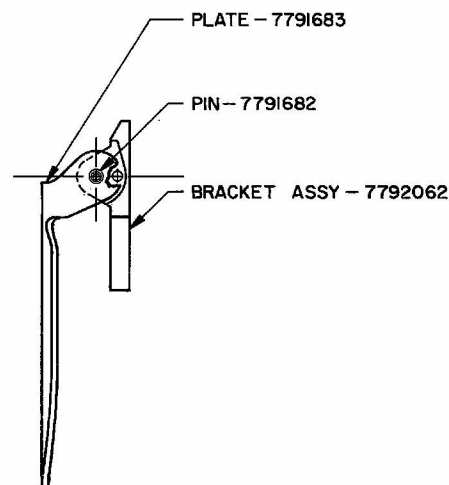
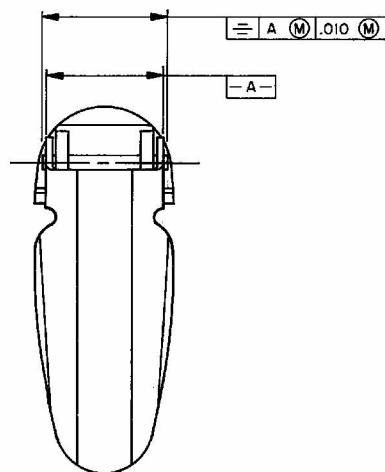
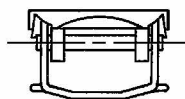
PART NO. 7791677

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING	23 SEP 63	SPRINGFIELD ARMORY U. S. ARMY WEAPONS COMMAND
YP		F11686528	RIFLE, M14E2	DRAFTSMAN	EPS	CHECKER
TS				TRACER	TMS	CHECKER
EL 2				ENGINEER	W. J. Langdon	ENGINEER
RA		SEE ENGINEERING RECORDS		SUBMITTED		
BH		NEXT ASSY	USED ON	APPROVED		
RH		DO NOT	APPLY PART NO			
SEE NOTE 2		MATERIAL		TOLERANCES ON DECIMALS ±		SCREW, WOOD, PAN HEAD, SLOTTED
		SEE NOTE 2		FRACTIONS ±		
		HEAT TREATMENT		ANGLES ±		CODE IDENT NO. DWG SIZE
		SEE NOTE 3				
		FINAL PROTECTIVE FINISH		APPROVED		19205 B 7791677
		FINISH 5.3.1.2 OR 5.3.2.2		W. J. Langdon		
		OF MIL-STD-171				SCALE 2/1 UNIT WT SHEET 1 OF 1

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U. S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

NOTES:

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
A	SEE EO SA 29263	18MAY66	<i>R. D. Cole</i>



FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 7791678

PART NO. 7791678

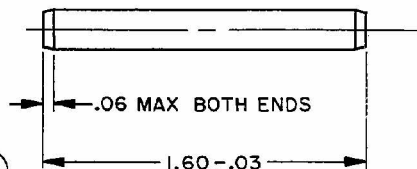
MECHANICAL PROPERTIES			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 23 SEP 63		SPRINGFIELD ARMOY U. S. ARMY WEAPONS COMMAND SPRINGFIELD 1. MASS. U. S. ARMY MATERIEL COMMAND	
YP	F11686528	RIFLE, M14E2	TOLERANCES ON DECIMALS $\pm$		DRAFTSMAN <i>[Signature]</i> CHECKER <i>EPS</i>		REST ASSEMBLY, SHOULDER	
TS			FRACTIONS $\pm$ ANGLES $\pm$		TRACER <i>TMS.</i> CHECKER <i>NJK</i>			
EL 2			MATERIAL		ENG. NEER <i>[Signature]</i> ENGINEER <i>[Signature]</i>			
RA	SEE ENGINEERING RECORDS		HEAT TREATMENT		SUBMITTED <i>[Signature]</i>			
BH	NEXT ASSY USED ON APPLICATION		FINAL PROTECTIVE FINISH		APPROVED <i>[Signature]</i>		CODE IDENT NO. DWG SIZE	
RH	DO NOT	APPLY PART NO					19205 C 7791678	
	AS SPECIFIED						SCALE 1/1 UNIT WT SHEET 1 OF 1	

NOTICE: WHEN GOVERNMENT DRAWINGS, SPECIFICATIONS, OR OTHER DATA ARE USED FOR ANY PURPOSE OTHER THAN IN CONNECTION WITH A DEFINITELY RELATED GOVERNMENT PROCUREMENT OPERATION, THE UNITED STATES GOVERNMENT THEREBY INCURS NO RESPONSIBILITY FOR ANY OMISSIONS WHATSOEVER, AND THE FACT THAT THE GOVERNMENT MAY HAVE FORMULATED, FORWARDED, OR IN ANY WAY SUPPLIED THE SAID DRAWINGS, SPECIFICATIONS OR OTHER DATA IS NOT TO BE REGARDED BY APPLICATION OR OTHERWISE AS IN ANY MANNER LICENSES THE HOLDER OR ANY OTHER PERSON OR CORPORATION, OR CONVEYING ANY RIGHTS OR PERMISSION TO MANUFACTURE, USE, OR SELL, ANY PATENTED INVENTION THAT MAY IN ANY WAY BE RELATED THERETO.

MECHANICAL PROPERTIES		DO NOT APPLY PART NO.		REVISIONS			
YP		APPLICATION		SYM	DESCRIPTION	DATE	APPROVAL
TS		NEXT ASSY	USED ON	A	(1-3) SEE EO SA 29263	18 MAY 66	<i>[Signature]</i>
EL2		SEE ENGINEERING RECORDS					
RA							
BH		C7791678	RIFLE,				
			MI4E2				
RH							

(A1)

SEE MILITARY STANDARD MS 51923-257 FOR DESCRIPTION OF THIS PART EXCEPT AS SPECIFIED HEREON:



(A2)

USED WITH REST  
ASSEMBLY, SHOULDER

(A3)

PART NO. 7791682

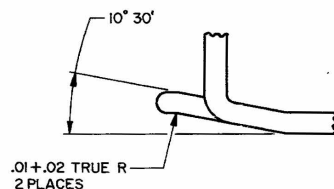
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON FRACTIONS DECIMALS ANGLES + - + - + - + -	ORIGINAL DATE OF DRAWING 23 SEP 63	SPRINGFIELD ARMORY SPRINGFIELD 1. MASS	
	DRAFTSMAN EPS CHECKER <i>[Signature]</i>	U. S. ARMY WEAPONS COMMAND	
	TRACER 924 CHECKER EPS	U. S. ARMY MATERIEL COMMAND	
MATERIAL	ENGINEER <i>[Signature]</i>	PIN, SPRING - TUBULAR, COILED	
SUBMITTED	<i>[Signature]</i>	CODE IDENT NO.	DWG SIZE
HEAT TREATMENT	APPROVED <i>[Signature]</i>	19205	A
FINAL PROTECTIVE FINISH	<i>[Signature]</i>	7791682	
SCALE 2/1		UNIT WT	SHEET 1 OF 1

SWESP 1181-1  
28 AUG 62

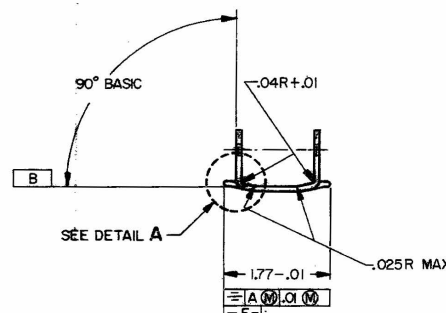
REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
A	(1) SEE EO SA 29263	18 MAY 66	MR
B	NOR W452051/840824	30 OCT 61	MR

NOTES: WHEN GOVERNMENT DRAWING SPECIFICATIONS TO DRAWING ARE USED FOR ANY PURPOSE OTHER THAN THE PURPOSE FOR WHICH THEY WERE DEVELOPED, THE USER SHALL BE RESPONSIBLE FOR THE CORRECTNESS OF THE INFORMATION CONTAINED HEREIN. THE USER SHALL BE RESPONSIBLE FOR THE CORRECTNESS OF THE INFORMATION CONTAINED HEREIN. THE USER SHALL BE RESPONSIBLE FOR THE CORRECTNESS OF THE INFORMATION CONTAINED HEREIN.

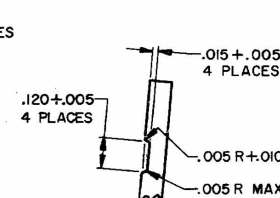
1. FINISH 125/.
2. ALL EDGES AND CORNERS SHALL BE BROKEN .005 ±.010 UNLESS OTHERWISE SPECIFIED.
3. HEAT TREATMENT: HEAT AT 1500°-1550°F. OIL QUENCH. TEMPER TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE.
4. RADIUS  $\boxed{-E-}$  SHALL BE TANGENT TO DIM  $\boxed{-F-}$  AND RADIUS  $\boxed{-D-}$ .
5. RADIUS  $\boxed{-C-}$  SHALL APPLY ALONG RADII  $\boxed{-H-}$ ,  $\boxed{-E-}$ , AND  $\boxed{-D-}$ .
6. SPEC MIL-W-13855 APPLIES



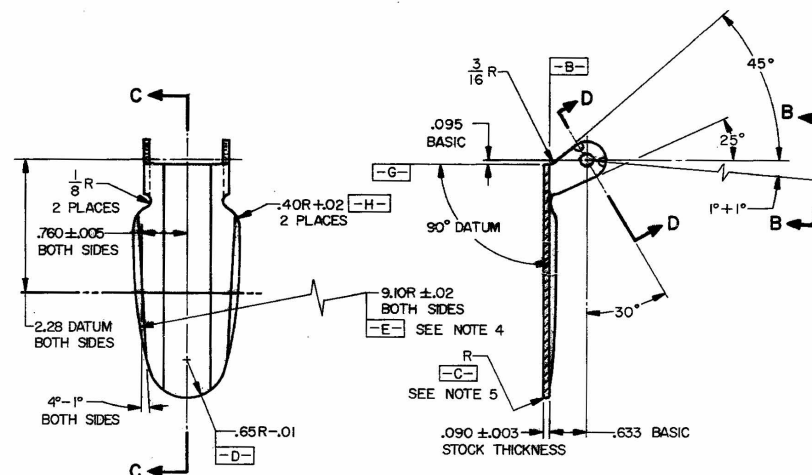
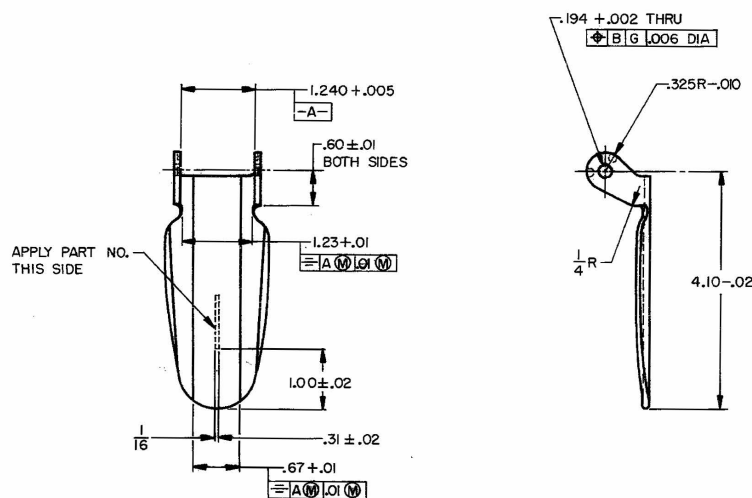
DETAIL A  
SCALE  $\frac{4}{1}$



SECTION D-D  
SCALE: 4/1



VIEW B-B  
SCALE: 4/1



SECTION C-C

CURRENT DESIGN ACTIVITY FSCM NO. 15200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

(A) PART NO. 7791683

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 23 SEP 63		SPRINGFIELD ARMOY U. S. ARMY WEAPONS COMMAND	
YP	C 7791678	RIFLE, M4E2		DRAWN	CHECKER	19205	D
YS				FRACTIONS $\frac{1}{64}$	ANGLES $\frac{1}{2}^\circ$	7791683	
EL 2				MATERIAL: HIGH CARBON STEEL, 1060 OR 1065, 897000000 1065	ENGINEER	7791683	
RA				HEAT TREATMENT SEE NOTE 3	ENGINEER	7791683	
BH				APPLY PART NO PER MIL-STD-130 AS SPECIFIED	ENGINEER	7791683	
RH	C40-46			FINAL PROTECTIVE FINISH FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-173	ENGINEER	7791683	

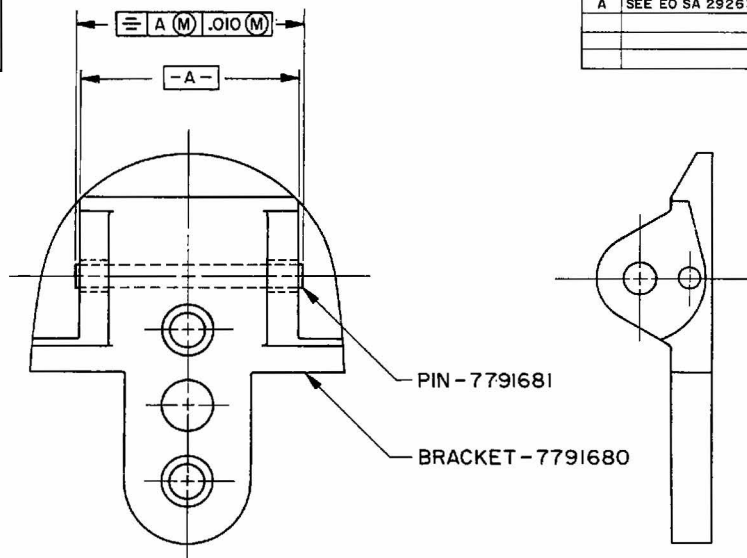
PLATE, SHOULDER REST

CODE IDENT NO. LOWS SIZE  
19205 D 7791683

SCALE 1/1 UNIT WT SHEET OF

NOTICE - WHEN GOVERNMENT DRAWINGS SPECIFICATIONS OR OTHER DATA ARE USED FOR ANY PURPOSE OTHER THAN IN CONNECTION WITH A DEFINITELY RELATED GOVERNMENT PROCUREMENT OPERATION, THE UNITED STATES GOVERNMENT THEREBY INCURS NO RESPONSIBILITY NOR ANY OBLIGATION WHATSOEVER, AND THE FACT THAT THE GOVERNMENT MAY HAVE FORMULATED, FURNISHED OR IN ANY WAY SUPPLIED THE SAID DRAWINGS, SPECIFICATIONS OR OTHER DATA IS NOT TO BE REGARDED BY IMPLICATION OR OTHERWISE AS IN ANY MANNER LICENSING THE HOLDER OR ANY OTHER PERSON OR CORPORATION OR CONVEYING ANY RIGHTS OR PERMISSION TO MANUFACTURE, USE OR SELL ANY PATENTED INVENTION THAT MAY IN ANY WAY BE RELATED THEREBY.

# NOTES:



REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
A	SEE EO SA 29263	18 MAY 66	<i>[Signature]</i>

FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 7792062

PART NO. 7792062

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING	23 SEP 63	SPRINGFIELD ARMORY U. S. ARMY WEAPONS COMMAND SPRINGFIELD 1, MASS. U. S. ARMY MATERIEL COMMAND	
YP	C 7791678	RIFLE, M14E2	TOLERANCES ON DECIMALS ±	DRAFTSMAN	EPS	CHECKER	PP
TS			FRACTIONS ±	TRACER	999	CHECKER	EPS
EL 2			ANGLES ±	ENGINEER	<i>[Signature]</i>	ENGINEER	<i>[Signature]</i>
RA	SEE ENGINEERING RECORDS		MATERIAL	SUBMITTED			
BH	NEXT ASSY	USED ON	HEAT TREATMENT	APPROVED	<i>[Signature]</i>		
RH	APPLICATION		FINAL PROTECTIVE FINISH				
	APPLY PART NO SEE DWG D 7791680						
	DO						

CODE IDENT NO.	DWG SIZE	
19205	B	7792062
SCALE 2/1	UNIT WT	SHEET 1 OF 1

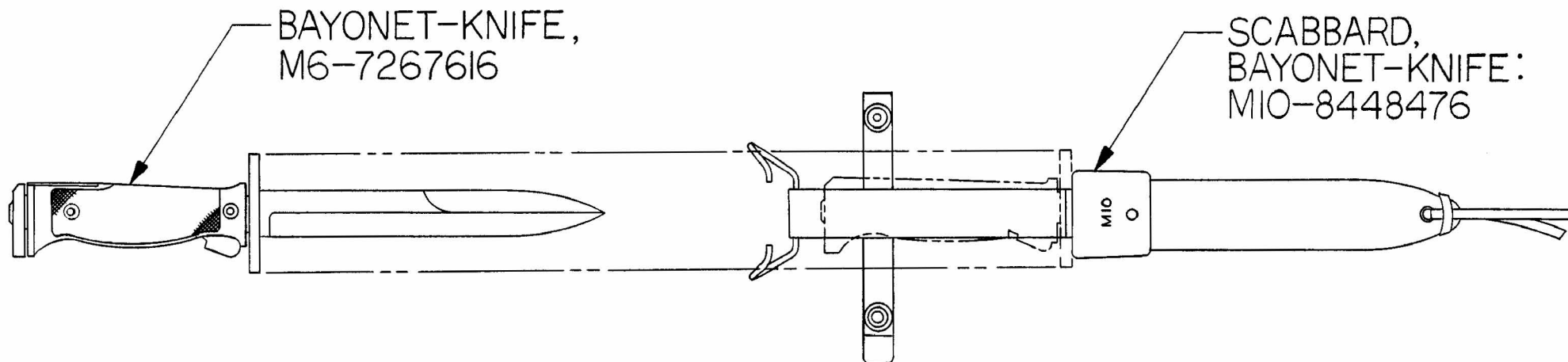
SWESP 1176-1  
28 AUG 62



NOTES:

I. MIL-W-13855 APPLIES.

REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
		C	REDRAWN W/CHANGE, SEE ERR HQR 20692	15 MAY 72
M		D	SEE ERR HQR 30617	22 JAN 73



SEE PL-8427015

(D)

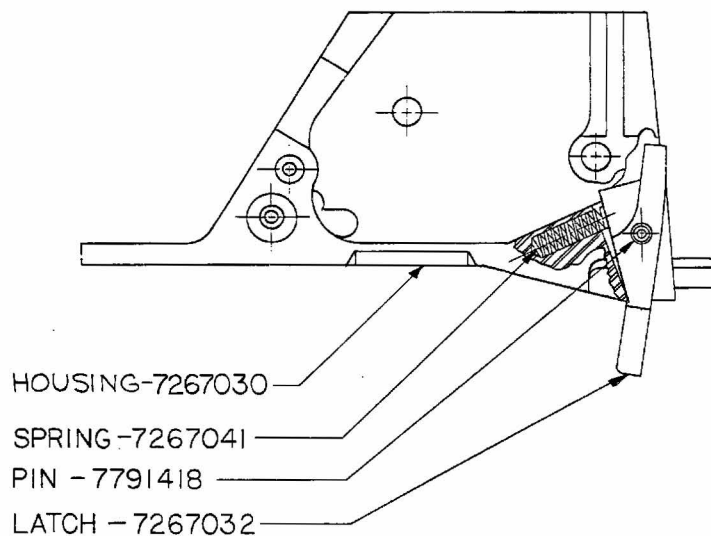
PART NO. 8427015

MECHANICAL PROPERTIES				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.		DEPT OF THE ARMY	
YS MIN				TOLERANCES:		DATE 25 FEB 64		U.S. ARMY WEAPONS COMMAND	
YS MAX				ANGLES ± —		PREP R. Passig		ROCK ISLAND, ILLINOIS, 61201	
EL 2				3 PLACE DECIMALS ± —		CHK S. F. Foster		BAYONET-KNIFE:	
RA		A12002927		2 PLACE DECIMALS ± —		ENGR E. G. Winter		M6, WITH SCABBARD	
BH				MATERIAL		SUBMITTED		SIZE B	
RH		NEXT ASSY		M14		APPROVED D. A. Cole		CODE IDENT NO. 19204	
		USED WITH		FINAL PROTECTIVE FINISH		R. S. Henry		DRAWING NO. 8427015	
		APPLICATION						SCALE 1/2	
								SHEET 1 OF 1	

NOTE:

MIL-W-13855 SHALL APPLY.

REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
		A	NOR W252025KJ/B4-02-10	84-04-20
		B	NOR W452051/840824 (ECP W952014/790608) (ECP W552069/85223)	860121
		C	ERR Z921237AE (ECP G9S3062/890718)	900308



ORIGINAL DESIGN ACTIVITY FSCM NO. 19204

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

SEE SEPARATE PARTS LIST-8448290

PART NO. 8448290

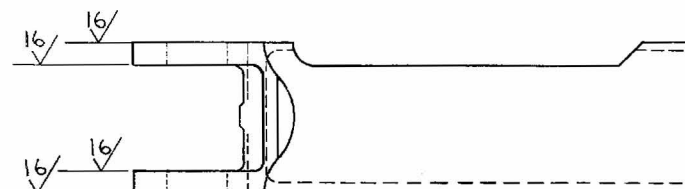
MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 8 MAY 1969		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
YP			TOLERANCES ON DECIMALS	DRAFTSMAN	CHECKER		
TS	9354354	RIFLE, 7.62 MM	ANGLES ±	C.J.L.	E.G.		
EL 2		M14NM	MATERIAL	TRACER	CHECKER		
RA		M21 SNIPER	HEAT TREATMENT	ENGINEER	E.W.F.		
BH	7790195	RIFLE, 7.62 MM		SUBMITTED			
RH		M14	FINAL PROTECTIVE FINISH	H.W. JOHNSON			
		NEXT ASSY. USED ON		APPROVED			
		APPLICATION		V.A. LUUKKONEN			

DWG SIZE	CODE IDENT NO.	
C	19204	8448290
SCALE 2/1	UNIT WT	SHEET 1 OF 1

NOTE:

AREAS FINISHED  $\sqrt{16}$  MAY HAVE  
PROTECTIVE FINISH REMOVED.  
APPLY LUBRICANT DWG. NO.  
8448693 TO THE FINISHED  
SURFACES PRIOR TO ASSEMBLY. (A)

MIL-W-13855 APPLIES.



NOTE: SAME AS 6008883 EXCEPT AS SHOWN

ORIGINAL DESIGN ACTIVITY FSCM NO. 19204

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

PART NO. 8448292

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 28 MAY 1969		DEPT OF THE ARMY	
YP	9354354	RIFLE 7.62MM:	TOLERANCES ON DECIMALS	DRAFTSMAN	CHECKER	ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
TS		MI4NM	ANGLES ± .XX ±	TRACER	CHECKER	HOUSING, HAMMER SPRING	
EL 2			MATERIAL	ENGINEER	ENGINEER		
RA			HEAT TREATMENT	SUBMITTED			
BH			FINAL PROTECTIVE FINISH	APPROVED			
RH							
NEXT ASSY:		USED ON:		DWG SIZE		CODE IDENT NO.	
APPLICATION				B		19204	8448292
				SCALE A / 1		UNIT WT	SHEET 1 OF 1

SWERI FORM 40B. 1 MAR 67

REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
		A	(1) SEE ERR HQR 10691	12 MAR 71
		B	NOR W252025 / 84 02 10	84-04-20
		C	NOR W452051/840824 (ECP W932014 / 790808) (ECP W552069 / 851223)	860121

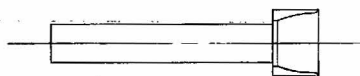
8448292

NOTE:

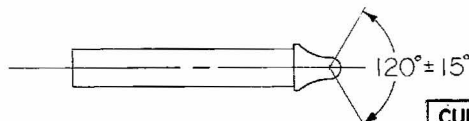
MIL-W-13855 SHALL APPLY.

REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
		A	NORW2S 2025 / 84-02-10	84-04-20
		B	NOR W452051 / 840824 (ECP W952014 / 790608) (ECP W552069 / 851223)	860121

APPROVED  
MR. *gmm*



16° THRU ANGLE SHOWN.  
APPLY LUBRICANT DWG. NO.  
8448693 TO THIS SURFACE



ORIGINAL DESIGN ACTIVITY FSCM NO. 19204

SAME AS 6008880 EXCEPT AS SHOWN

CURRENT DESIGN ACTIVITY FSCM NO.19200  
US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

PART NO. 8448692

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.		DEPT OF THE ARMY	
YS MIN		9324354	RIFLE 7.62MM :	DATE	11 MAR 1971	U.S. ARMY WEAPONS COMMAND	
YS MAX			MI4 NM	PREP	R. DECAPP	ROCK ISLAND, ILLINOIS, 61201	
EL 2				CHK		PLUNGER, HAMMER SPRING	
RA				ENGR	<i>R.H.M.</i>		
BH				SUBMITTED	<i>C.W. Fuhrmann</i>	SIZE	CODE IDENT NO.
RH				APPROVED	<i>C.W. Fuhrmann</i>	B	19204
APPLICATION		FINAL PROTECTIVE FINISH		DRAWING NO.		8448692	
				SCALE		2/1	
				SHEET		OF	

B8448692

## NOTES:

## 1. OPTICAL CHARACTERISTICS:

- 1.1 MAGNIFICATION (VARIABLE)  
1.1.1 3.0 POWER  $\pm .25$  TO 9 POWER  $\pm .5$

## 2. OPTICAL REQUIREMENTS:

- 2.1 PARALLAX: FOCUS PARALLAX BETWEEN CENTER OF THE RETICLE AND IMAGE OF A TARGET AT 300 METERS  $\pm 20$  METERS SHALL NOT EXCEED 1/2 MINUTE AT 0X, 3/4 MINUTE AT 6X, AND 3/4 MINUTE AT 3.0X (AZIMUTH AND ELEVATION KNOBS SET AT MIDPOINT OF TRAVEL).
- 2.2 LINE OF SIGHT SHIFT: WHEN VIEWING A TARGET AT 300 METERS  $\pm 20$  METERS THE SHIFT IN THE LINE OF SIGHT AT THE 6X AND 9X POSITIONS SHALL NOT EXCEED 1/2 MINUTE RELATIVE TO THE LINE OF SIGHT POSITION AT 3.0X (\*) APPLIES.
- 2.3 RESOLUTION: AT THE CENTER OF THE FIELD OF VIEW THE TELESCOPE SHALL RESOLVE 1/6 MINUTE AT 9 POWER, 1/4 MINUTE AT 6 POWER, AND 1/3 MINUTE AT 3.0 POWER. THE EYEPiece SHALL BE ADJUSTED FOR BEST FOCUS AND NO AUXILIARY MAGNIFICATION SHALL BE USED (AZIMUTH AND ELEVATION KNOBS SET AT MIDPOINT OF TRAVEL).
- 2.4 AZIMUTH AND ELEVATION ADJUSTMENT: WITH THE LINE OF SIGHT ORIGINALLY PARALLEL (WITHIN 3 MINUTES) TO THE MECHANICAL AXIS OF THE TELESCOPE, THE EXTREME ROTATION OF THE AZIMUTH AND ELEVATION KNOBS SHALL CHANGE THE LINE OF SIGHT BY A MINIMUM OF 23 MINUTES OF ARC IN BOTH DIRECTIONS. (MAGNIFICATION SET AT 3.0 POWER.)
- 2.5 DIOPTRER ADJUSTMENT: USING A DIOPTRER THE EYEPiece ADJUSTMENT SHALL PROVIDE AT LEAST PLUS 1.0 DIOPTERS AND MINUS 1.0 DIOPTERS FROM THE POSITION OF BEST FOCUS ON THE RETICLE SURFACE, ESTABLISHED BY USING A DIOPTRER SET FOR ZERO DIOPTERS.
- 2.6 COATINGS: ALL LENS SURFACES SHALL BE COATED WITH AN ANTI-REFLECTION COATING OF MAGNESIUM FLUORIDE
- 2.7 CLEANLINESS:  
2.7.1 THERE SHALL BE NO EVIDENCE OF GLASS FRACTURE, LENS SEPARATION, GREASE, OR FINGERPRINTS ON ANY OPTICAL COMPONENT WHEN SIGHTING THRU THE OBJECTIVE OR EYE END OF THE TELESCOPE.  
2.7.2 WHEN VIEWING FROM THE EYE END OF THE TELESCOPE THERE SHALL NOT BE MORE THAN 3 PARTICLES OF DIRT VISIBLE ON THE RETICLE SURFACE. IN ADDITION, NO PARTICLE SHALL EXCEED THE APPARENT WIDTH OF A RETICLE LINE. THIS CHECK SHALL BE PERFORMED AT BOTH THE 3.0 POWER AND 9 POWER POSITIONS.
- 2.8 GLASS OPTICS  
2.8.1 THE OPTICAL GLASS SHALL MEET THE REQUIREMENT OF GRADE C OF SPECIFICATION MIL-G-174.  
2.8.2 DIGS AND SCRATCHES AS DESCRIBED IN PARAGRAPH 3.5.2 AND 3.5.3 OF SPECIFICATION MIL-G-13830 SHALL BE IN ACCORDANCE WITH PARAGRAPH 3.5.5.

## 3. ENVIRONMENTAL REQUIREMENTS:

- 3.1 PRESSURE TEST  
3.1.1 SCOPE TO BE PRESSURIZED TO 1.3 P.S.I.G. TO 70°F. (ROOM TEMPERATURE). NO PRESSURE DROP PERMITTED FOR 20 SECONDS.
- 3.2 FOGGING TEST  
3.2.1 WITH SCOPE SUBMERGED IN WATER AT 130°F. FOR 20 SECONDS, NO MOISTURE SHALL BE VISIBLE ON ANY INTERNAL SURFACE OF TELESCOPE.
- 3.3 TORQUE TEST (70°F)  
3.3.1 TORQUE REQUIRED TO TURN ELEVATION AND WINDAGE KNOBS TO BE 1 1/2 IN. LBS. TO 3.0 IN. LBS.  
3.3.2 TORQUE REQUIRED TO TURN POWER RING TO BE 3 IN. LBS. TO 10 IN. LBS.  
3.4 ADJUSTABLE EYEPiece, ELEVATION AND WINDAGE KNOBS AND CAM TO BE MANUALLY OPERABLE AT + 10°F. TO + 125°F.  
3.5 SHOCK REQUIREMENT: SHOCK IN LONGITUDINAL PLANE, 400 TO 500 G'S PEAK LEVEL. TIME DURATION TO BE 7 TO 1.1 MIL-SECONDS. EACH TELESCOPE/MOUNT SYSTEM MUST BE CAPABLE OF MEETING THE SHOCK REQUIREMENT FOR A MINIMUM OF 5000 CYCLES.

## 4. PERFORMANCE: WITH THE VERTICAL RETICLE LINE "PLUMB" WITHIN 1 DEGREE AND CAM SET AT 3 POWER POSITION (0-DEGREE REFERENCE). THE FOLLOWING REQUIREMENTS FOR DEPRESSION OF THE "LINE-OF-SIGHT" AT THE FOLLOWING MAGNIFICATION SETTINGS SHALL BE MET WHEN ROTATING THE CAM:

MAGNIFICATION	DEPRESSION OF LINE OF SIGHT (MINUTES OF ARC)
3.0X	0
4X	3.1 $\pm$ 1.0 MINUTE
5X	7.8 $\pm$ 1.0 MINUTE
6X	13.1 $\pm$ 1.0 MINUTE
7X	19.1 $\pm$ 1.5 MINUTES
8X	26.0 $\pm$ 1.5 MINUTES
9X	33.8 $\pm$ 2.0 MINUTES

## CARRYING CASE REQUIREMENTS ARE AS FOLLOWS:

- WATERTIGHTNESS: THE CASE SHALL SHOW NO EVIDENCE OF WATER PENETRATION WHEN SUBMERGED AND COVERED WITH A MINIMUM OF 3 INCHES TO MAXIMUM OF 6 INCHES OF WATER FOR 5 MINUTES. WATER TEMPERATURE SHALL BE BETWEEN 40°F. AND 75°F.

## 5. MOUNTING REQUIREMENTS: THE TELESCOPE MUST BE CAPABLE OF BEING SECURELY MOUNTED ON A M14MM OR M21 RIFLE TO MEET THE SHOCK REQUIREMENTS OF NOTE 3.5 AND IN ADDITION:

- 5.1 CENTERLINE OF SCOPE MUST BE 2.0  $\pm$  1/4  $\pm$  0 INCHES ABOVE THE CENTERLINE OF THE RIFLE BORE.  
5.2 THE EYEPiece OF THE TELESCOPE MUST BE LOCATED 12.0  $\pm$  1/4  $\pm$  0 INCHES FORWARD OF THE BUTT STOCK FACE.

## 6. IDENTIFICATION OF THE "SUGGESTED SOURCES OF SUPPLY" HEREON IS NOT TO BE CONSTRUED AS A GUARANTEE OF PRESENT OR CONTINUED AVAILABILITY AS A SOURCE OF SUPPLY FOR THE ITEM.

## 7. SUGGESTED SOURCE OF SUPPLY:-

LEATHERWOOD, JAMES M.  
ROUTE 1, BOX 111  
STEPHENVILLE, TX 76401  
P/N 5888-791-1  
NSN 1240-01-107-9068

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
A	REPLACES REV - W/CHG NORW252010 82-07 21	82 08 25	<i>[Signature]</i>
B	NORW252023/84-02-10 (ECP W452000/84-03-15)	84 04 20	<i>[Signature]</i>

## SPECIFICATION CONTROL DRAWING

PART NO. 9349352

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

TELESCOPE, STRAIGHT

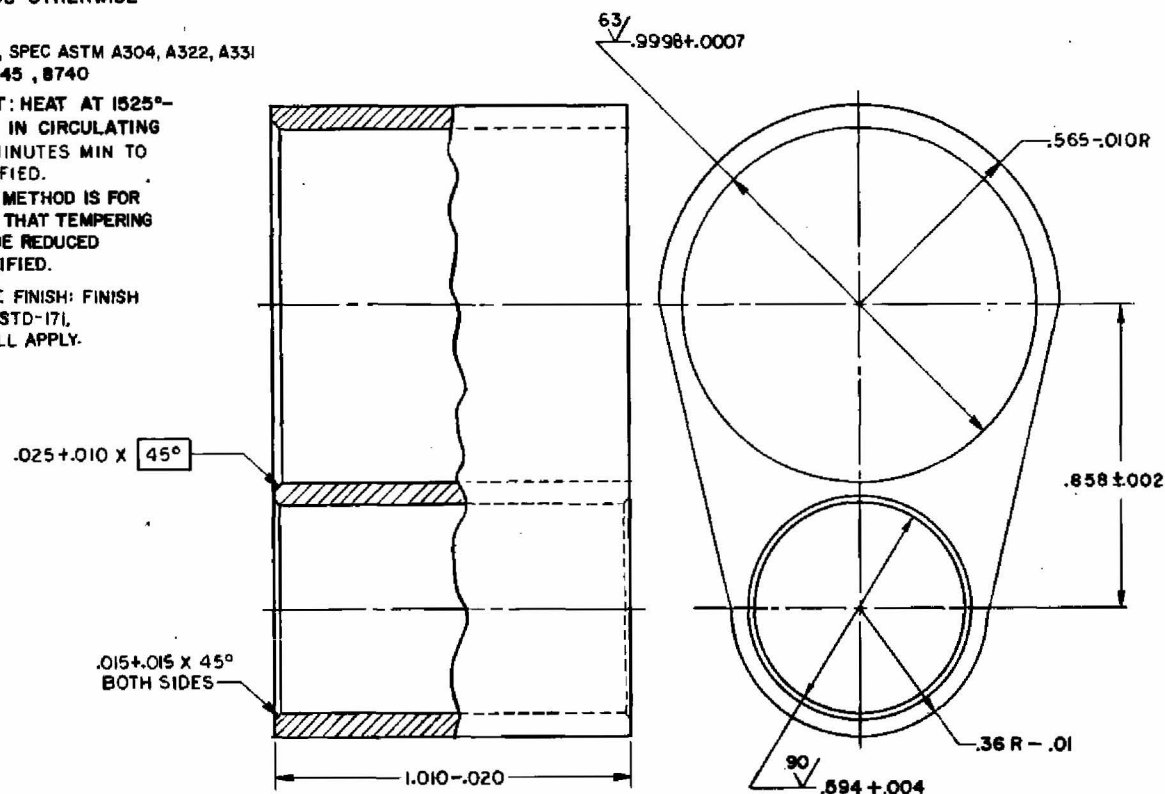
SIZE F  
FSCM NO. 19200  
9349352

SCALE UNIT WT. SHEET

MECHANICAL PROPERTIES		DO NOT SCALE DRAWING		ORIGINAL DATE OF DRAWING 81-11-17		U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801	
VP		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		UNITS/STRT	UNITS/STRT		
TS		TOLERANCES ON DECIMALS $\pm$		ENGR	ENGR		
ELP		FRACTIONS $\pm$ ANGLES $\pm$		ENGR	ENGR		
RA							
BN							
RI							
RIFLE 7.62MM.				8448270			
NEXT ASSY		SNIPERS: M21		USED ON			
APPLICATION							

# NOTES

1. FINISH  $\sqrt{125}$  EXCEPT AS NOTED.
2. ALL EDGES SHALL BE BROKEN .005+.010 UNLESS OTHERWISE SPECIFIED.
3. MATERIAL: STEEL, SPEC ASTM A304, A322, A331 4140, 8640, 8645, 8740
4. HEAT TREATMENT: HEAT AT 1525°-1550° F. QUENCH IN CIRCULATING OIL. TEMPER 30 MINUTES MIN TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
5. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OF MIL-STD-171,
6. MIL-W-13855 SHALL APPLY.



PART NO. 9349846

<b>PHYSICAL PROPERTIES</b> TP TS ELI RA BH BH		RIFLE M14MM F9362529 C 32-40	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ANGLES $\pm 1^\circ$ FRACTIONS $\pm 1/64$ MATERIAL SEE NOTE 3 HEAT TREATMENT SEE NOTE 4 FINAL PROTECTIVE FINISH SEE NOTE 5	ORIGINAL DATE OF DRAWING 82-03-02 DRAWN BY JG CHECKED TRACED ENGINEER SUBMITTED APPROVED Sallee, C. Allen Richard R. Moll	U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER BOVER, NEW JERSEY 07001 GUIDE, OPERATING ROD ESCM NO 19200 9349846 SCALE 4/1 UNIT WT C
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A	ECPW552069 / 850823 NORW452051 / 840824	860121	RA
-	PRODUCTION RELEASE ERR W352005	830610	RA
XO			
REV	DESCRIPTION	DATE	APPROVED

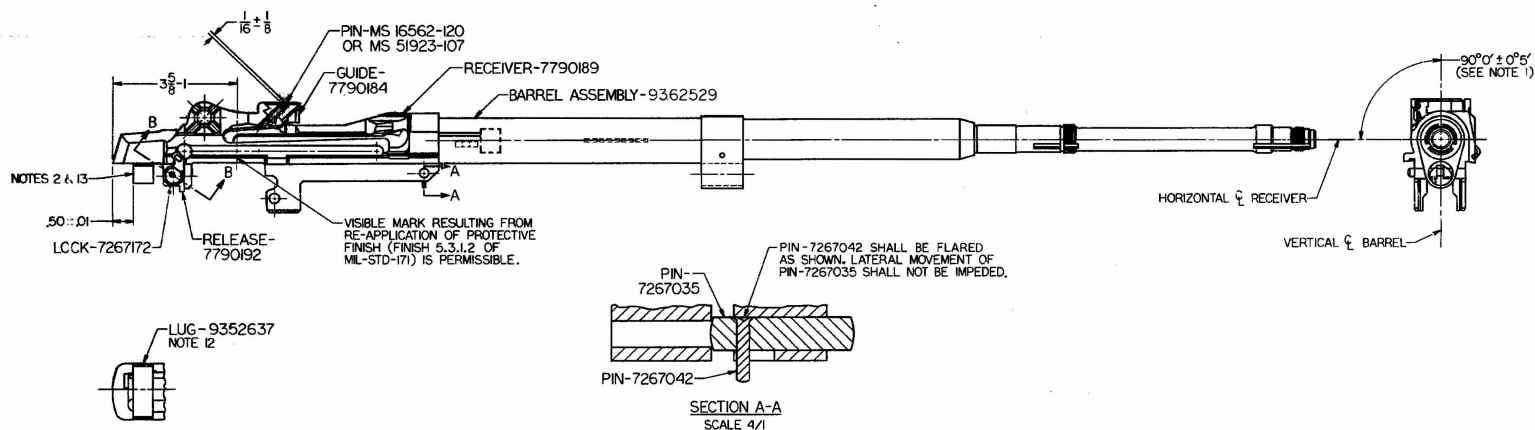
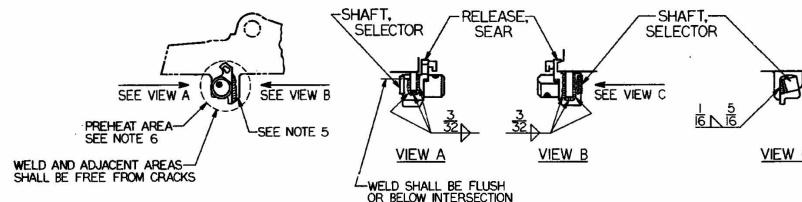
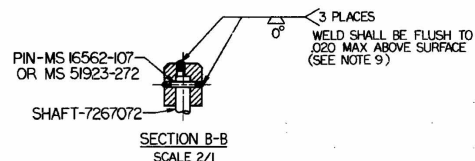






## NOTES:-

- 1-WHEN THE BARREL IS ASSEMBLED IN THE POSITION SHOWN, THE DRAW SHALL NOT BE BROKEN BY A DISASSEMBLY TORQUE OF LESS THAN 80 LB FT.
- 2-WELDING MATERIAL:-FILLER METAL; MIL-E-21562, TYPE MIL-ENGA.
- 3-WELDING SHALL BE IN ACCORDANCE WITH MIL-W-8611, USING ELECTRIC ARC, INERT GAS SHIELDED NON-CONSUMABLE ELECTRODE.
- 4-ALL WELDED AREAS SHALL BE SUITABLY CLEANED AND FREE OF PHOSPHATE COATING AND OTHER CONTAMINANTS THAT COULD HAVE AN ADVERSE AFFECT ON WELDS BEFORE WELDING.
- 5-RELEASE SEAR (VIEW B) SHALL BE POSITIONED AGAINST LOWER SURFACE OF SEAR RELEASE LUG OF RECEIVER BEFORE WELDING.
- 6-INDICATED AREA SHALL BE PREHEATED TO 400°F BEFORE WELDING. A CONTACT PYROMETER, PYROMETRIC CRAYONS OR LACQUERS, OR OTHER SUITABLE MEANS TO INDICATE PREHEAT TEMPERATURE SHALL BE USED. REDUCED HARDNESS OF COMPONENTS IN THE PREHEAT AREA IS PERMISSIBLE. ADEQUATE CONTROL SHALL BE MAINTAINED TO PREVENT SOFTENING OF RECEIVER BEYOND PREHEAT AREA.
- 7-THE WELDED COMPONENTS IN THE PREHEAT AREA SHALL BE CLEANED AND FREE OF SCALE OR OTHER CONTAMINANTS THAT COULD ADVERSELY AFFECT APPLICATION OF FINISH BEFORE REAPPLYING PROTECTIVE FINISH.
- 8-FILLET WELDS (VIEWS A, B, & C) MAY BE FREE OF PROTECTIVE FINISH.
- 9-PLUG WELDS (SEC. B-B) SHALL BE TOUCHED UP IN ACCORDANCE WITH NOTE 10.
- 10-MIL-W-13855 SHALL APPLY.
- 11-WELDING OF LOCK, RELEASE, SHAFT AND RECEIVER IS PERMISSIBLE AFTER HEAT TREATMENT AND PRIOR TO THE APPLICATION OF PROTECTIVE FINISH. FINISH 5.3.1.2 OF MIL-STD-171 SHALL APPLY TO THIS WELDED ASSEMBLY.
- 12-LUG MUST NOT EXTEND BEYOND RECEIVER SIDES AFTER WELDING.
- 13-SURFACES OF LUG WELDS SHALL BE SMOOTH AND FLAT TO A POSITIVE DRAFT ANGLE OF 15° MAX, TO ASSURE CAPABILITY OF DISASSEMBLING, WITHOUT DAMAGE TO THE BEDDING MATERIAL OF THE RECEIVER AND BARREL ASSEMBLY FROM THE BEDDING COMPOUND IN THE STOCK, SHOULD.



SEE SEPARATE PARTS LIST-9352636

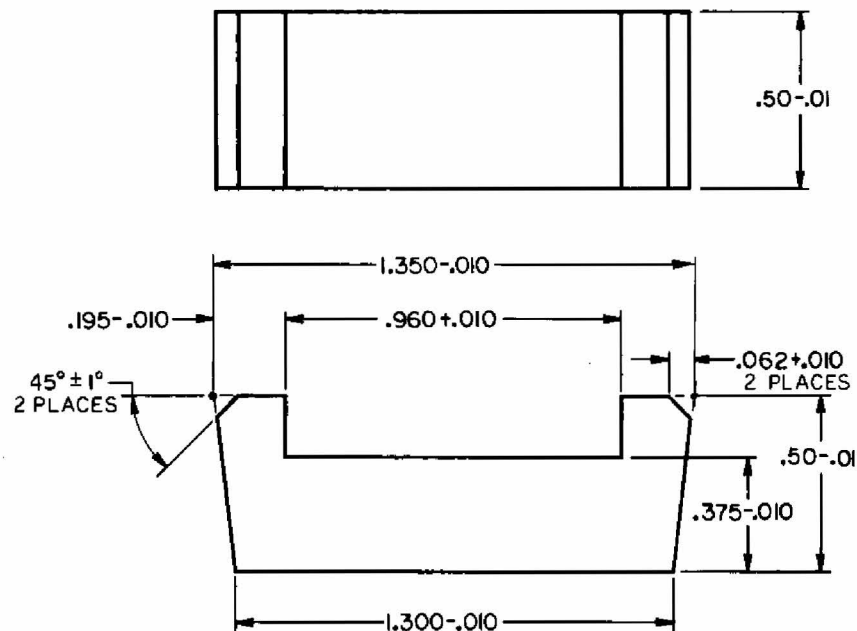
PART NO. 9352636

USE SEPARATE PARTS FOR DIMENSIONS			FURNISHING		
MECHANICAL PROPERTIES		DO NOT SCALE DRAWING	ORIGINAL DATE OF DRAWING		U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DEVIL, NEW JERSEY 07001
TP	UNLESS OTHERWISE SPECIFIED	DIMENSIONS ARE IN INCHES	82-05-24		BARREL AND RECEIVER ASSEMBLY
TS	TOLERANCES ON DECIMALS	± .005	UNLESS OTHERWISE SPECIFIED		
LL	FRACTIONS	± .005	UNLESS OTHERWISE SPECIFIED		
BN	ANGLES	± .005	UNLESS OTHERWISE SPECIFIED		
OTHER		± .005	UNLESS OTHERWISE SPECIFIED		SIZE FSCM NO. 19200 9352636
APPLICATION		DO NOT SCALE DRAWINGS	SHEET 1 OF 1		SCALE 1/1 UNIT: IN.

## NOTES:

- 1-SPEC MIL-W-13855 APPLIES.
- 2-MATERIAL:-COLD-FINISHED CARBON STEEL BAR  
GRADE 1020, SPEC ASTM-A108.
- 3-FINISH 32/ MINIMUM ALL OVER.
- 4-DIMENSIONS SPECIFIED ARE TO THEORETICAL  
SHARP CORNERS.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERR W4S2051/ 840824 (ECP-W5S2069R/ 851223)	860121	<i>AM</i>



PART NO. 9352637	
U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801	
LUG, RECOIL	
SIZE C	FSCM NO. 19200
9352637	
SCALE	UNIT WT.
SHEET	

APPLICATION	
9352636	RIFLE, 7.62MM
	M14NM
NEXT ASSY	USED ON
MECHANICAL PROPERTIES	
YP	
TS	
EL2	
RA	
BH	
RH	

DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON DECIMALS *	
FRACTIONS * ANGLES *	

ORIGINAL DATE OF DRAWING 86 01 21	
DRAFTSMAN JAR	CHECKER <i>OK</i>
ENGR <i>AS</i>	ENGR
ENGR <i>JP</i>	ENGR

*1.000*  
*Emil Meny*

REVISIONS			
BY	DESCRIPTION	DATE	APPROVAL
XO			
-	PRODUCTION RELEASE ERR W4S2051 / 840824 (ECPW5S2069R1 / 851223)	860121	<i>2/1</i> <i>RNA</i>
A	NOR G7S2063 / 871103	880129	<i>ORF</i> <i>2/1</i>
B	NOR G7S3187 / 871221	880712	<i>CGT</i> <i>2/1</i>
C	NOR G8S3084 / 880823	890823	<i>VJS</i> <i>2/1</i>

## NOTES:

## 1.-MATERIAL: WOOD:-

## A-SPEC MIL-W-13871 TYPE I OR TYPE II

- (1) THE GRAIN SHALL BE CLOSE ALONG ITS ENTIRE LENGTH IN DIRECTION OF THE LONGITUDINAL AXIS.  
(2) FOR INFORMATION ONLY-THIS STOCK MAY BE FABRICATED FROM A BLANK 35 X 3 X 7.  
B-LAMINATED WOOD USING TYPE I AND TYPE II IS PERMISSIBLE. THE LAMINATING ADHESIVE WILL BE IN ACCORDANCE WITH SPEC MIL-A-5534 OR MIL-A-22397.

## 2.-ALTERNATIVE MATERIAL:-

## A-THE FOLLOWING WOODS ARE ALLOWABLE PROVIDING THEY COMPLY WITH THE REQUIREMENTS IN 2.A.(2)

- (1) SYCAMORE  
BIRCH  
PECAN  
RED BIRCH  
MAPLE  
BLACK LOCUST.

## (2) REQUIREMENTS —

- (A) NOT TO INCLUDE MORE THAN 10% SOLID SAPWOOD, EXCEPT FOR MAPLE AND BIRCH (WHICH IS MOSTLY SAPWOOD).  
(B) THE KNOT SIZE MUST BE LIMITED TO A PIN KNOT NO MORE THAN 1/4 INCH EACH  
(C) FREE OF CHECKS, DECAY, SHAKE, SPLIT, AND BRASHNESS  
(D) SMALL REPAIRABLE DEFECTS IN THE BUTT AND FORE END ARE ALLOWABLE. SPEC MIL-STD-1270 APPLIES.  
(E) THE ABOVE DEFECTS ARE DEFINED IN THE NATIONAL HARDWOOD LUMBER ASSOCIATIONS RULES FOR THE MEASUREMENT AND INSPECTION OF HARDWOOD AND CYPRESS, JANUARY 1982

B-PLASTIC (PRE MIX MOULDING COMPOUND) MIL-P-43043. MOULDED STOCK MUST WEIGH A MINIMUM OF 2.5 LBS.

COLOR: FED-STD-595 FOREST GREEN 34079.

3.-FINISH: WOOD STOCK (IN THE WHITE) SMOOTH READY FOR STAINING.

4.-MIL-W-13855 APPLIES.

C	—	—	C
B	B	B	B
SH 4	SH 3	SH 2	SH 1
REVISION STATUS OF SHEETS			

PART NO. 9352638

		MECHANICAL PROPERTIES		DO NOT SCALE DRAWING— UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL SIZE OF DRAWING 84-05-09		U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801	
		TP				DRAWN GAD-RSR	CHECKED <i>apt</i>	STOCK, GUN, SHOULDER	
		TS				ENGR	ENGR		
		SLR				ENGR	ENGR		
		BA						SIZE <b>C</b> FSCM NO. <b>19200</b> 9352638	
9381706	M14NM.	SH							
NEXT ASSY	USED ON	SH							
APPLICATION								SCALE —	SHEET 1 OF 4

## NOTES:-

5-UNLESS OTHERWISE SPECIFIED, CORNERS AND EDGES SHALL BE BROKEN .01 MAX AND FILLETS SHALL BE .01 MAX.  
6-ALL DIMENSIONS APPLY WHEN THE STOCK HAS 6% TO 8% MOISTURE CONTENT.

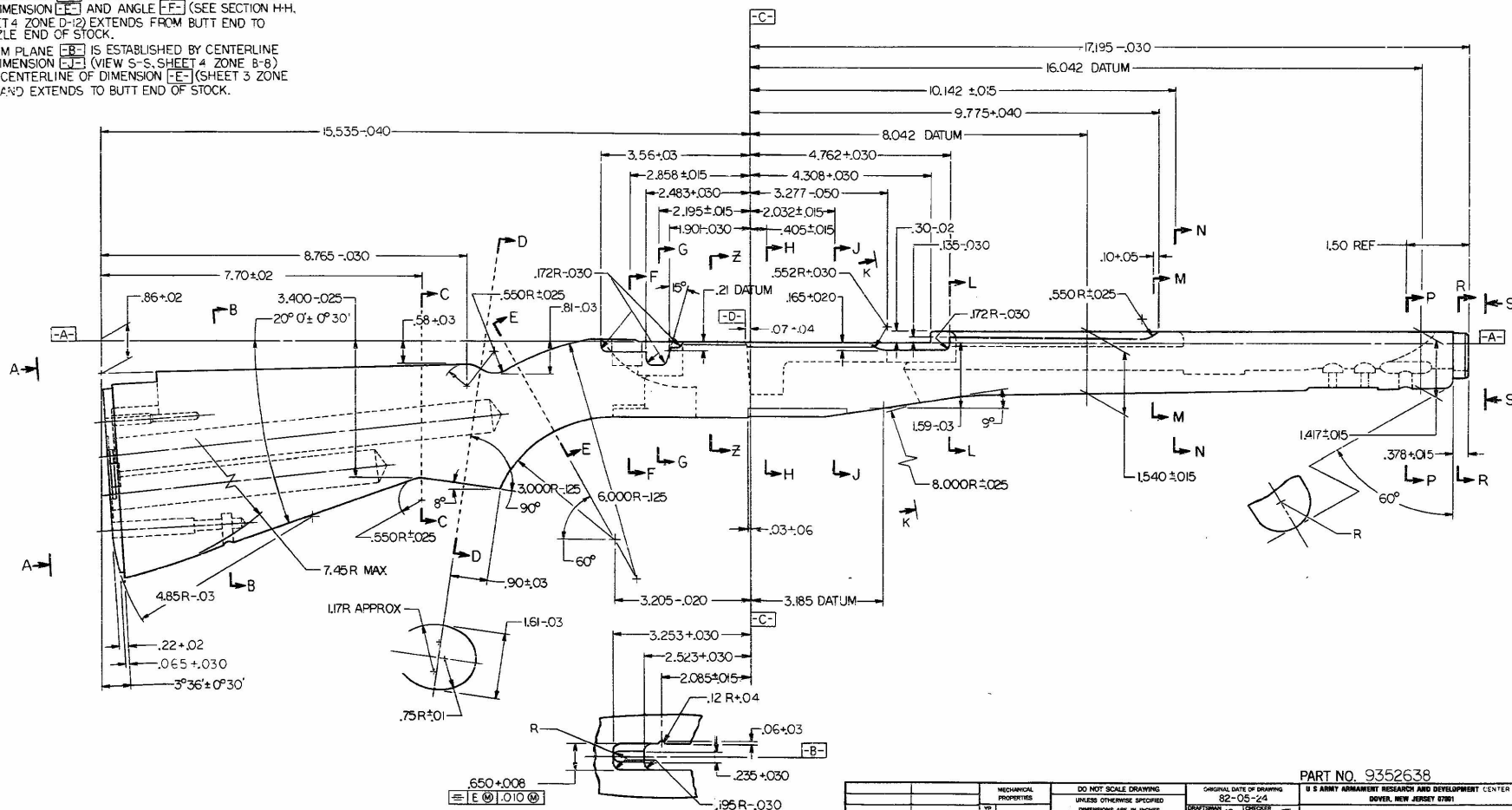
10.-THIS PART IS USED TO MAKE STOCK, GUN.  
SHOULDER 9392337 (MODIFIED FOR RIFLE M14NM).

REVISIONS			
REV	DESCRIPTION	DATE	APPROVAL
1	PRODUCTION RELEASE SEE ERR W452051 / 840824 E.C.P. W55205101 / 851223	960121	<i>[Signature]</i>
2	WGR 6753167/871221	980712	<i>[Signature]</i>

7-.00+.01 MISMATCH PERMISSIBLE BETWEEN RADIUS [H] SHEET 2 ZONE A-3, AND PLANE [G], SHEET 2 ZONE B-3.

8-DATUM PLANE [A] ESTABLISHED AT INTERSECTIONS OF DIMENSION [E] AND ANGLE [F] (SEE SECTION H-H, SHEET 4 ZONE D-12) EXTENDS FROM BUTT END TO MUZZLE END OF STOCK.

9-DATUM PLANE [B] IS ESTABLISHED BY CENTERLINE OF DIMENSION [J] (VIEW S-S, SHEET 4 ZONE B-8) AND CENTERLINE OF DIMENSION [E] (SHEET 3 ZONE G-4) AND EXTENDS TO BUTT END OF STOCK.



PART NO. 9352638

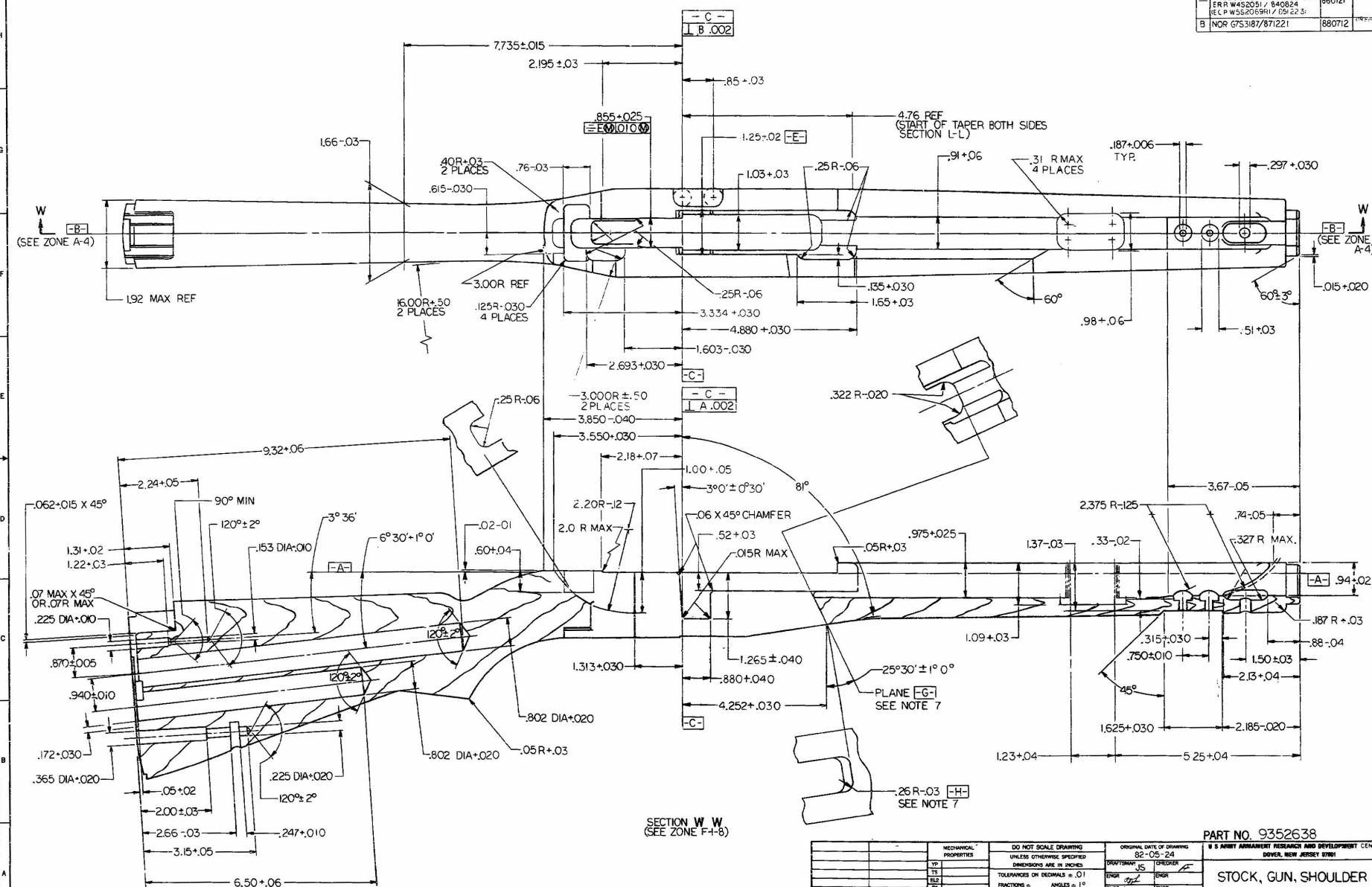
U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

STOCK, GUN, SHOULDER

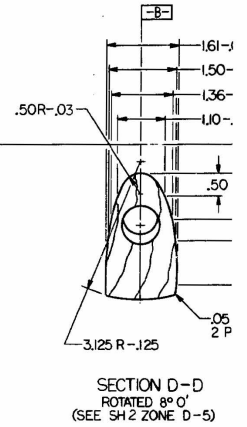
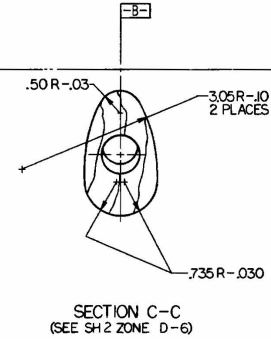
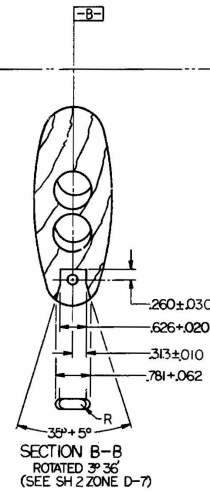
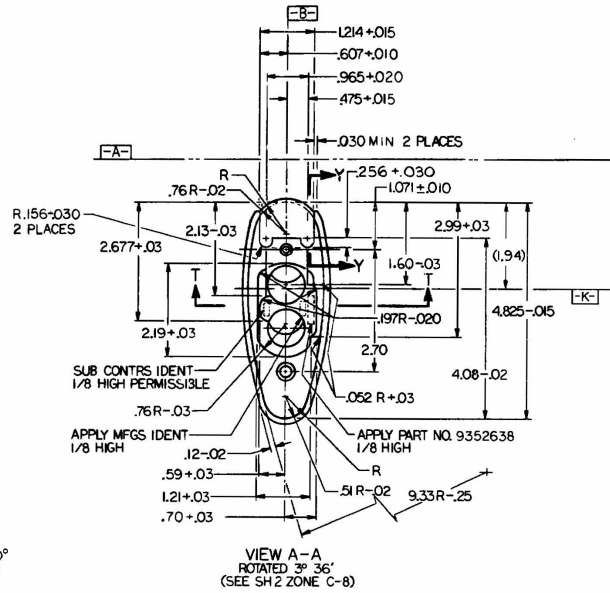
SCALE FCSM NO. 19200 9352638  
SHEET OF 1

MECHANICAL PROPERTIES		DO NOT SCALE DRAWING		ORIGINAL DATE OF DRAWING	
VT	TS	UNLESS OTHERWISE SPECIFIED	UNLESS OTHERWISE SPECIFIED	82-05-24	82-05-24
TS	ELD	DIMENSIONS ARE IN INCHES	DIMENSIONS ARE IN INCHES	JS	JS
EP	EP	TOLERANCES ON DECIMALS = .01	TOLERANCES ON DECIMALS = .01	JS	JS
RR	RR	FRACTIONS = 16	FRACTIONS = 16	JS	JS
NEXT ASSY		USED ON		APPLICATION	

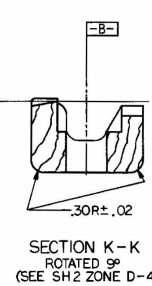
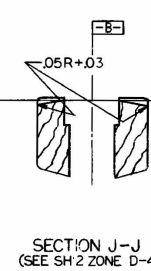
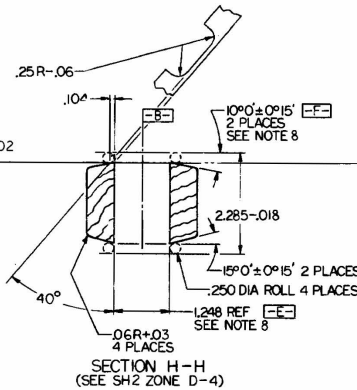
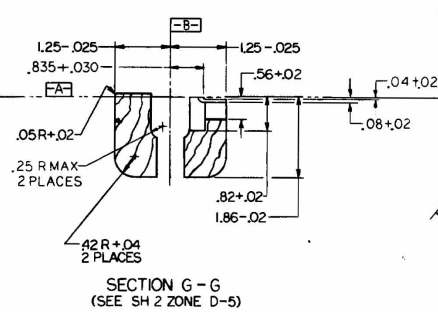
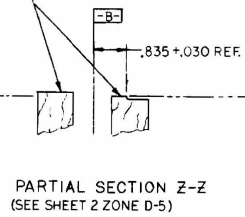
REVISIONS			
REV	DESCRIPTION	DATE	APPROVAL
1	PRODUCTION RELEASE SEE ERR W452051 / 840824 REL P W552059H1 / 091223	860121	94H
2	NOR GFS3187/871221	880712	24H



PART NO. 9352638			
U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801			
STOCK, GUN, SHOULDER			
SIZE F	FSCM NO. 19200	9352638	
SCALE 1/1	UNIT IN.	SHEET 3 OF 1	



THESE SURFACES CHANGE TO 10°  
ANGLE SHOWN IN SECTION H-H  
AT PLANE -D-

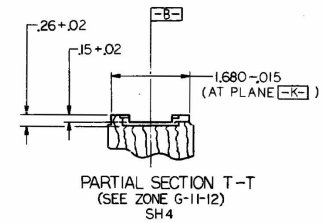
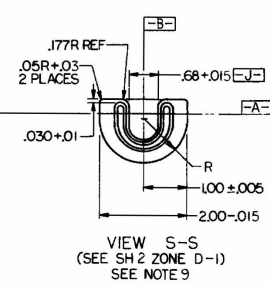
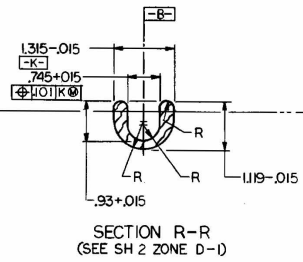
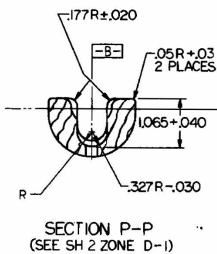


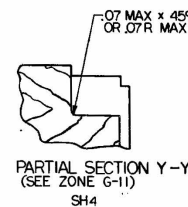
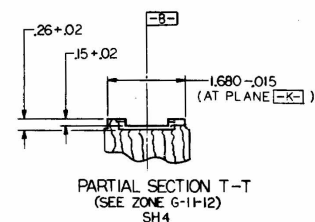
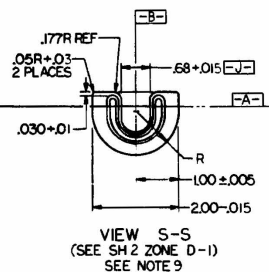
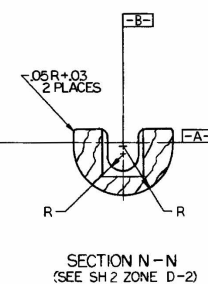
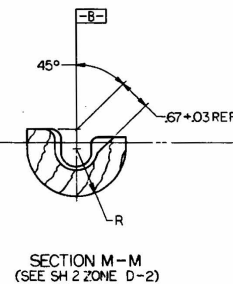
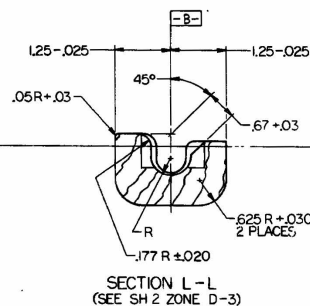
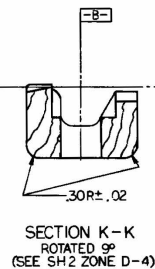
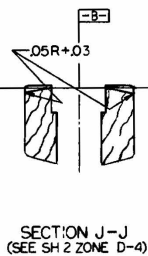
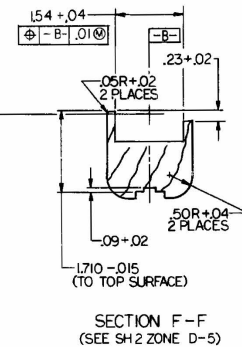
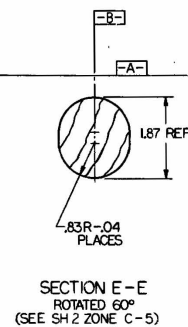
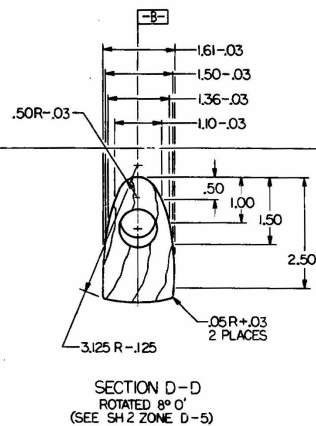
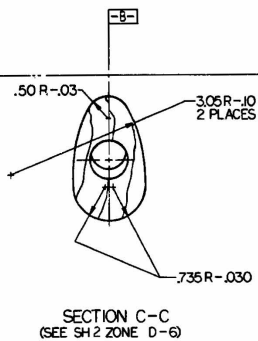
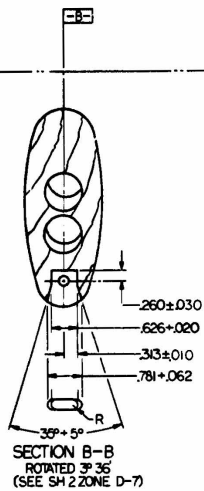
SE  
(SEE

J9352638

F-1/2 SH.4

REVC





REV	DESCRIPTION	DATE	APPROVAL
1	PRODUCTION RELEASE SEE ERR W452051/840824 (ECP W552051/840824)	860121	
2	NOR 6753187/71221	880712	
3	NOR 6853084/880823	890623	

**F-212**

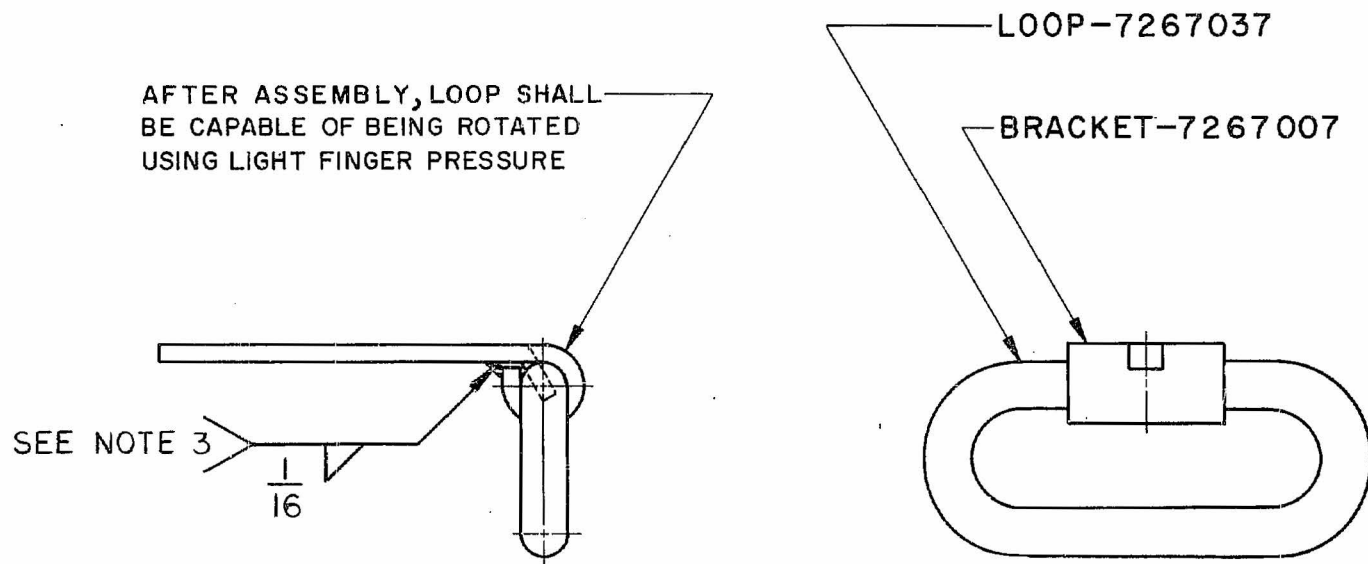
MECHANICAL PROPERTIES		DO NOT SCALE DRAWING		ORIGINAL DATE OF DRAWING		PART NO. 9352638	
TP	15	UNLESS OTHERWISE SPECIFIED	UNLESS OTHERWISE SPECIFIED	82-05-24	82-05-24	U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER	
EL2	15	DIMENSIONS ARE IN INCHES	DIMENSIONS ARE IN INCHES	82-05-24	82-05-24	DOVER NEW JERSEY OFFICE	
RA	15	TOLERANCES ON DECIMALS ±	TOLERANCES ON DECIMALS ±	82-05-24	82-05-24	STOCK, GUN, SHOULDER	
RA	15	FRACTIONS ±	FRACTIONS ±	82-05-24	82-05-24	SIZE J FSCM NO. 19200	
RA	15	ANGLES ±	ANGLES ±	82-05-24	82-05-24	9352638	
RA	15	ANGLES ±	ANGLES ±	82-05-24	82-05-24	SCALE 1/1 UNIT IN	
RA	15	ANGLES ±	ANGLES ±	82-05-24	82-05-24	SHEET 4 OF 4	
RA	15	ANGLES ±	ANGLES ±	82-05-24	82-05-24	2 F.	



NOTE:--

- 1-SPEC MIL-W-13855 AND ANSI Y14.5-1973 APPLY.
- 2-PROTECTIVE FINISH:--FINISH 5.3.1.2  
OF MIL-STD-171 AFTER WELDING.
- 3-WELD IN ACCORDANCE WITH SPEC MIL-W-8611.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
XO			
-	PRODUCTION RELEASE ERR W2S 2025	84-04-20	<i>AW</i> <i>EB</i> <i>M</i> <i>1</i>
A	NORW4S2051 / 840824 (ECPW5S2069 / 851223)	860121	<i>DLK</i> <i>BM</i>



SEE SEPARATE PARTS LIST 9352716

PART NO. 9352716

		MECHANICAL PROPERTIES		DO NOT SCALE DRAWING		ORIGINAL DATE OF DRAWING 82-06-01		U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801	
				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAFTSMAN <i>AS</i>		CHECKER	
		YP		TOLERANCES ON DECIMALS $\pm .01$		ENGR <i>AS</i>		ENGR	
		TS		FRACTIONS $\pm 1/64$ ANGLES $\pm 1^\circ$		ENGR <i>RJA</i>		ENGR	
		EL2				<i>A. Aron</i> <i>Edward J. Brennan</i>		SIZE B	
		RA						FSCM NO. 19200	
9381706		RIFLE, M14NM		BH				9352716	
NEXT ASSY		USED ON		RH				SCALE 2/1	
APPLICATION								UNIT WT.	
								SHEET	

1. SPEC MIL-W-13855 AND ANSI Y14.5-1973 APPLY.

## 2. MATERIAL:

A- FOR WROUGHT MATERIAL:-  
HOT ROLLED ALLOY STEEL BARS, GRADE 4140,  
ASTM A322.

ALTERNATIVE MATERIAL:-  
STEEL BAR ALLOY, COLD-FINISHED, 4140 H.  
ASTM A331.

B- FOR PRECISION CASTING:-  
STEEL, 1C-4140, SPEC MIL-S-22141 EXCEPT  
CARBON .43 TO .53 PERCENT. TENSILE TEST  
SHALL NOT APPLY. CLASSIFICATION AND INSPECTION  
OF INVESTMENT CASTINGS TO BE IN ACCORDANCE  
WITH CLASS 2, GRADE A, EXCEPT CROSS HATCHING  
AREA TO BE CLASS 1, GRADE A, SPEC MIL-C-6021  
(SEE SHEET 2).

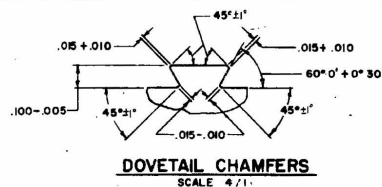
3- HEAT TREATMENT (FOR MATERIALS A AND B):  
BEFORE MACHINING, HEAT AT 1550°F TO 1575°F. OIL  
QUENCH TEMPER 30 MINUTES AT HEAT TO HARDNESS  
SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE  
EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED  
BELOW THAT SPECIFIED.

4. FINISH 125✓ ALL OVER.

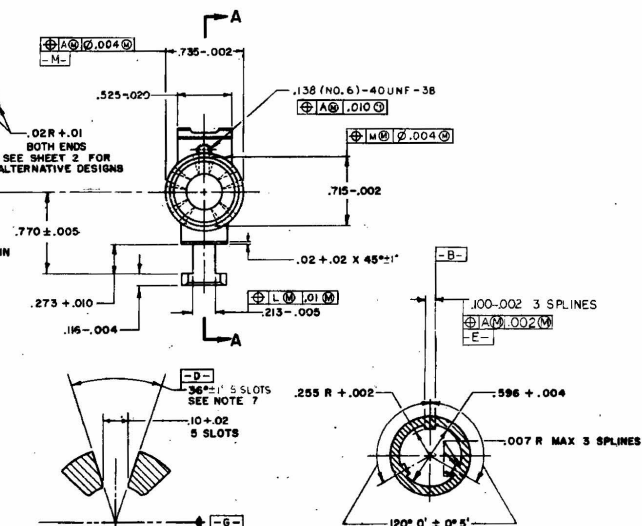
5. ALL EDGES SHALL BE BROKEN .005 + .010 UNLESS OTHERWISE SPECIFIED.

6. ☐ **H** ESTABLISHED BY ☐ **A** AND ☐ **F** .

7. ☐ **D** (TOP SLOT) SHALL BE IN ALIGNMENT WITH ☐ **E** .  
(TOP SPLINE) WITHIN 2°

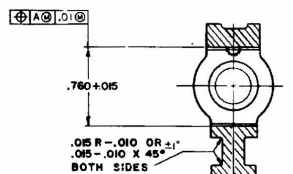


**DETAIL M**

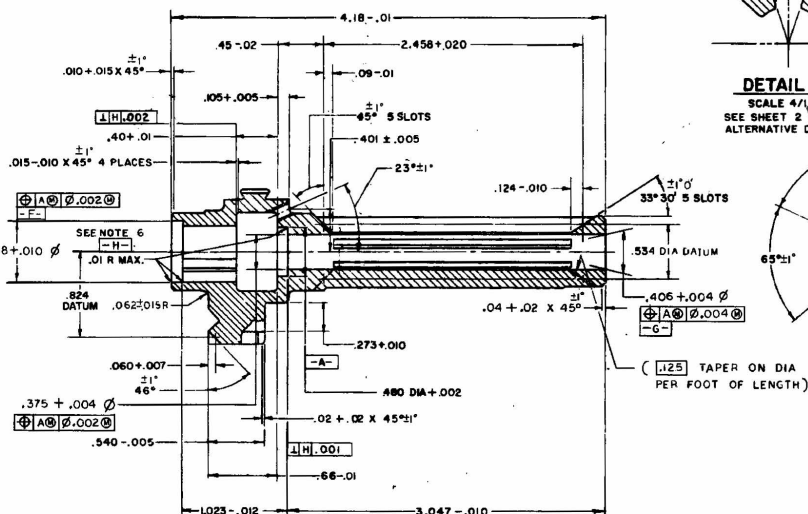


**DETAIL L**

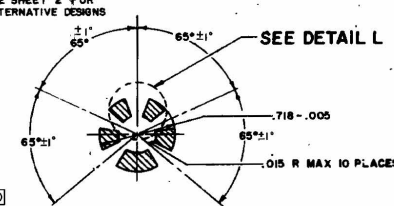
**SECTION C-C**  
SEE SHEET 2 FOR ALTERNATIVE DESIGN



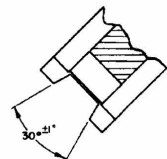
**SECTION D-D**



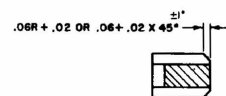
**SECTION A-A**  
SEE SHEET 2 FOR ALTERNATIVE DESIGNS



**SECTION E-E**



**PARTIAL SECTION K-K**  
SCALE 4/1



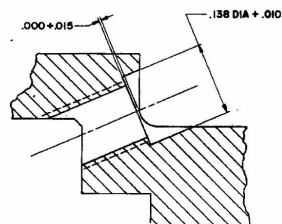
SECTION H-H

REVISONS			
SYM	DESCRIPTION	DATE	APPROV
XC			
-	PRODUCTION RELEASE ERR W2S2025	840420	<i>WLS</i>
A	NOR W4S2051/840824 ECP W5S2029/851223	860121	<i>WLS</i>

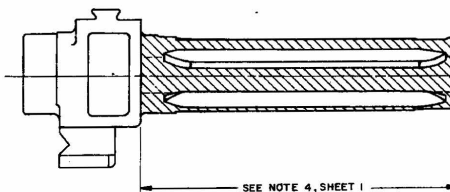
MECHANICAL PROPERTIES TP TS ELG BA		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES (IN DECIMALS) - .01 FRACTIONS - 1/16 ANGLES - 1°		ORIGINAL DATE OF DRAWING 82-06-07 DRAFTSMAN <i>W</i> CHECKER		PART NO. 9352718 U S ARMY AMMUNITION AND DEVELOPMENT CENTER DUYEN, NEW JERSEY 07801	
J 938694 RFLM14 NM NEXT ASSY USED ON		FINAL PROTECTIVE FINISH FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171		L. J. <i>John</i> <i>John</i>		SIZE F FSCM NO. 19200 9352718	
APPLICATION		RH -29-36		SCALE 2/1 UNIT WY		SHEET 1 OF 2	

## NOTES:-

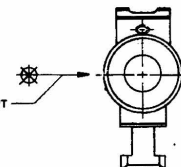
ALL DIMENSIONS AND REQUIREMENTS  
ON SHEET 1 SHALL APPLY EXCEPT  
AS SPECIFIED.



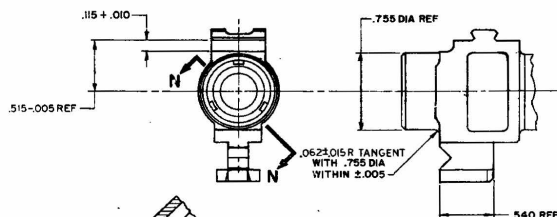
DETAIL P  
SCALE 10/1



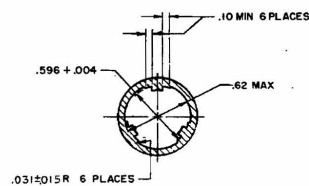
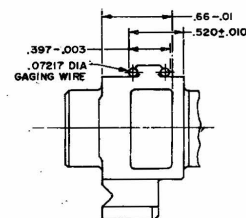
SEE NOTE 2  
RT  
SHEET 1



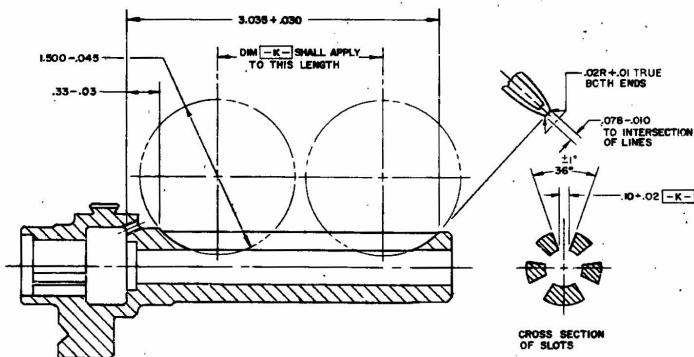
SEE NOTE 4, SHEET 1



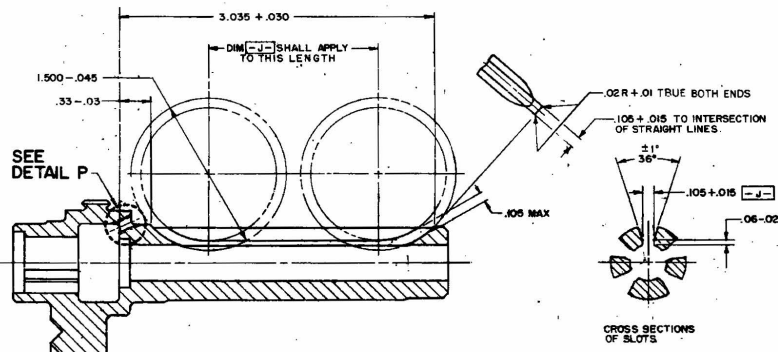
PARTIAL SECTION N-N



SECTION C-C  
SEE SHEET 1



SECTION A-A  
SEE SHEET 1



SECTION A-A  
SEE SHEET 1

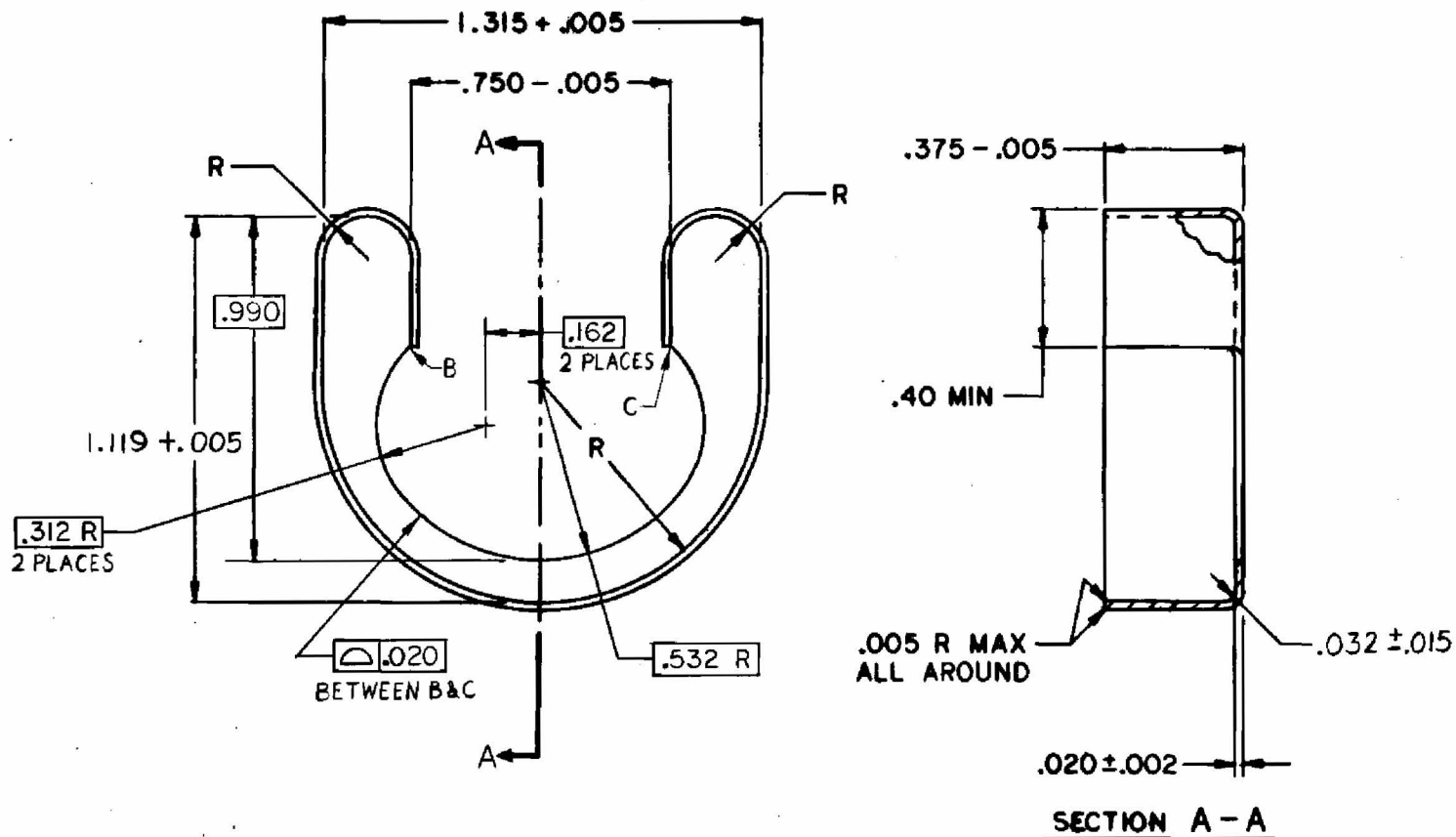
POSITION NUMBERS	NUMBER OF POSITIONS	NO. OF FILMS	NO. OF VIEWS PER FILM	FILM SIZE
1	1	1	50 TO 55	14 X 17

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
XO			
	PRODUCTION RELEASE	84 04 20	
	ERR WES 2025		
A	NORW452051 / 84 08 24	85 01 21	
	(ECPW552069 / 85 12 23)		

MECHANICAL PROPERTIES		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS - .01 FRACTIONS - 1/16 ANGLES - 1°		ORIGINAL DATE OF DRAWING 82-06-07 DRAFTSMAN CHECKER		U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801	
VP		TS		ENGR		SUPPRESSOR, FLASH	
ELZ		ENGR		ENGR			
RA		ENGR		ENGR			
BH		ENGR		ENGR			
SEE SH1							
NEXT ASSY		USED ON		SCALE 2/1		FSCM NO. 19200	
APPLICATION				UNIT WT		9352718	
				SHEET 2 OF 2			

3-FINISH 5.3.1.2 OR 5.3.2.2  
OF MIL-STD-171.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
XO			
-	PRODUCTION RELEASE ERR W2S 2025	84-04-20	EFW [Signature]
A	NORW4S2051 / 84 08 24 (ECPW5S2069 / 85 12 23)	86 01 21	[Signature] M. [Signature]



U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

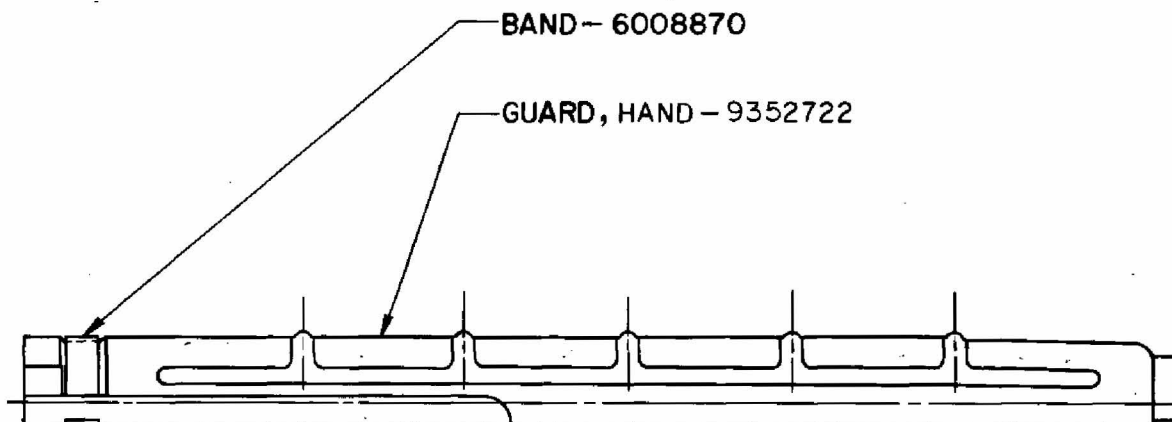
FERRULE, STOCK

		MECHANICAL PROPERTIES		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 82-06-01		U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801	
		YP		TOLERANCES ON DECIMALS $\pm .01$ FRACTIONS $\pm \frac{1}{16}$ ANGLES $\pm 1^\circ$		DRAFTSMAN	AT	CHECKER	FERRULE, STOCK
		TS				ENGR		ENGR	
		EL2				ENGR	RJH	ENGR	
		RA				I am Edward J. Brennan			
9381706	RIFLE, M14NM	BH				SIZE	FSCM NO.	9352720	
NEXT ASSY	USED ON	RH				C	19200		
APPLICATION						SCALE	4/1	UNIT WT.	SHEET

## NOTES:-

1- SPEC MIL-W-13855 SHALL APPLY.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
XO			
-	PRODUCTION RELEASE ERR W2S2025	86-01-21	<i>HW</i>
A	NOR W4S2051/840824 ECP W5S2069/851223	86-01-21	<i>M</i>



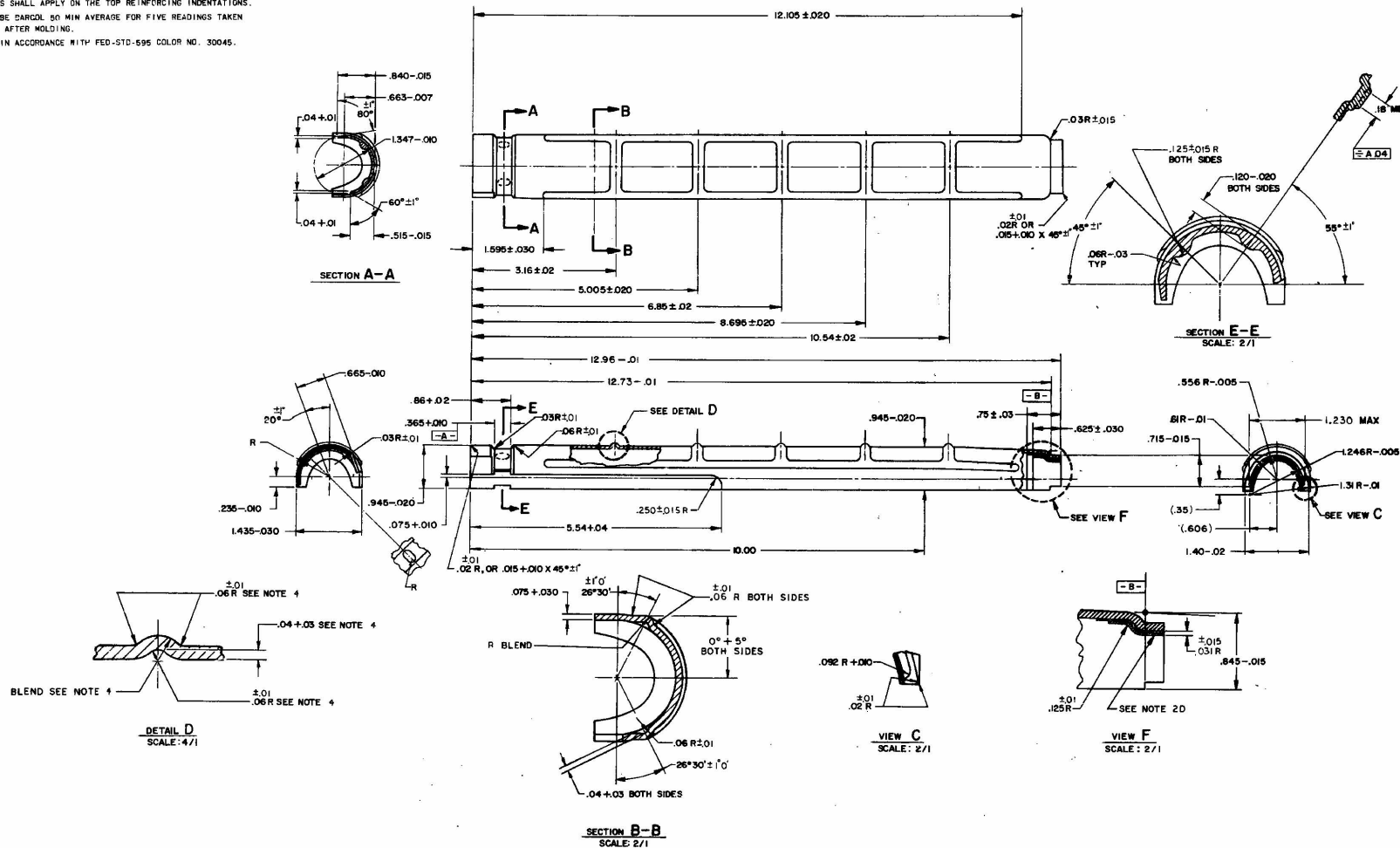
SEE SEPARATE PARTS LIST 9352721

PART NO. 9352721


		MECHANICAL PROPERTIES		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 82-06-01		U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801	
		YP		TOLERANCES ON DECIMALS $\pm .01$ FRACTIONS $\pm \frac{1}{16}$ ANGLES $\pm 1^\circ$		DRAFTSMAN <i>AT</i> CHECKER		GUARD ASSEMBLY, HAND	
		TS				ENGR <i>RTA</i> ENGR			
		EL2				ENGR <i>L. Anis</i>		SIZE C FSCM NO. 19200	
		RA				ENGR <i>Edward Roma</i>		9352721	
J9386974		RIFLE, M14 NM						SCALE 1/1 UNIT WT. SHEET	
NEXT ASSY		USED ON							
APPLICATION									

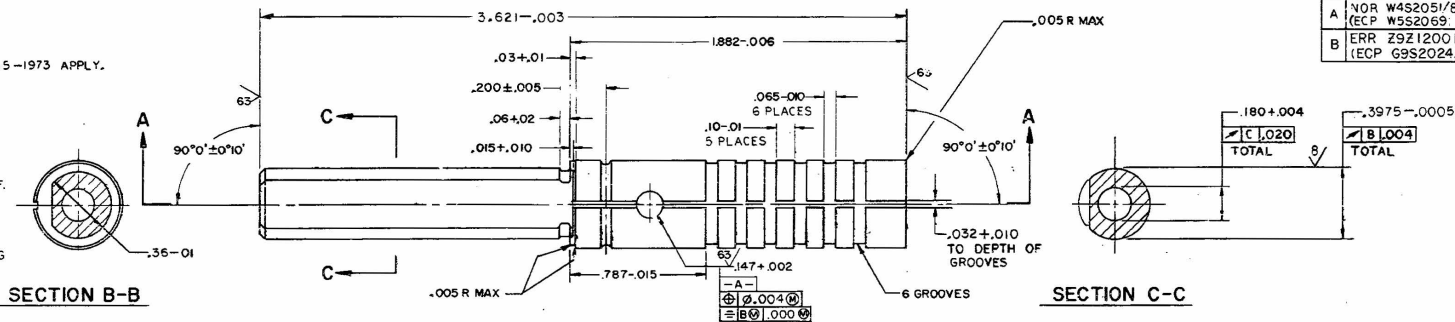
3. DRAFT ANGLES WITHIN TOLERANCE ZONES PERMITTED.
4. THESE DIMENSIONS SHALL APPLY ON THE TOP REINFORCING INDENTATIONS.
5. HARDNESS SHALL BE BARCOL 50 MIN AVERAGE FOR FIVE READINGS TAKEN WITHIN 24 HOURS AFTER MOLDING.
6. COLOR SHALL BE IN ACCORDANCE WITH FED-STD-595 COLOR NO. 30045.

PART NO. 9352722			
U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801			
GUARD , HAND			
SIZE F	FSCM NO 19200	9352722	
SCALE 1/1	UNIT WT.	SHEET	OF 1

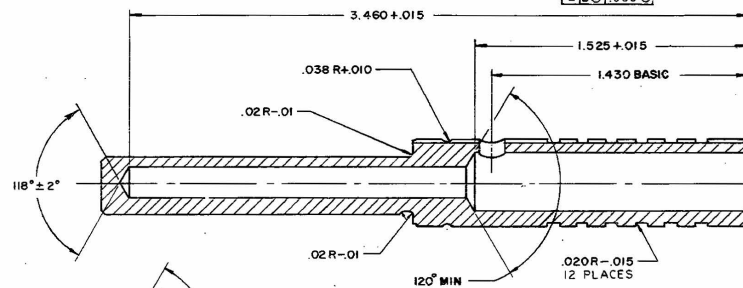


NOTES:-

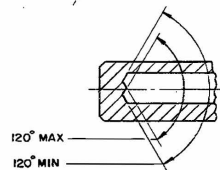
- 1- SPEC MIL-W-13855 AND ANSI Y14.5-1973 APPLY.  
2- FINISH 125/ EXCEPT AS NOTED.  
3- ALL EDGES SHALL BE BROKEN 0.10  
MAX UNLESS OTHERWISE SPECIFIED.  
4- MATERIAL: STEEL, CORROSION RESISTING  
FED SPEC QQ-S-763; CLASS 420,  
CONDITION A EXCEPT: COPPER 0.50% MAX.  
5- HEAT TREATMENT: HEAT AT 1800° TO 1850°F.  
AIR QUENCH. TEMPER 30 MINUTES AT  
A MINIMUM TEMPERATURE OF 850°F,  
TO HARDNESS SPECIFIED.  
HEAT TREATMENT METHOD IS FOR  
GUIDANCE EXCEPT THAT TEMPERING  
TIME SHALL NOT BE REDUCED BELOW  
THAT SPECIFIED.
- 



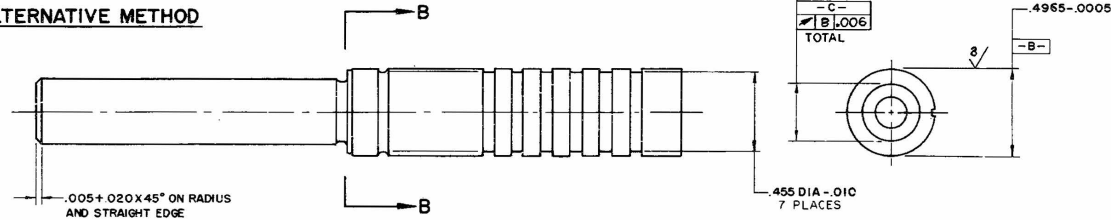
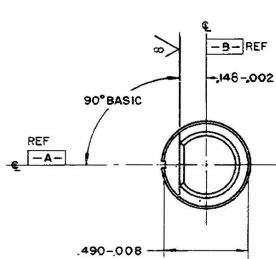
REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
XO			
—	PRODUCTION RELEASE ERR W2S 2025	8404-20	WJ GS
A	NOR W4S2051/840824 (ECP W5S2069 / 851223)	860121	ES
B	ERR Z9Z1200M (ECP G9S2024/890518)	891016	DECI-CAT ES



**SECTION A-A**



### ALTERNATIVE METHOD



PART NO. 9352724

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

PISTON

SIZE	FSCM NO.	
D	19200	9352724

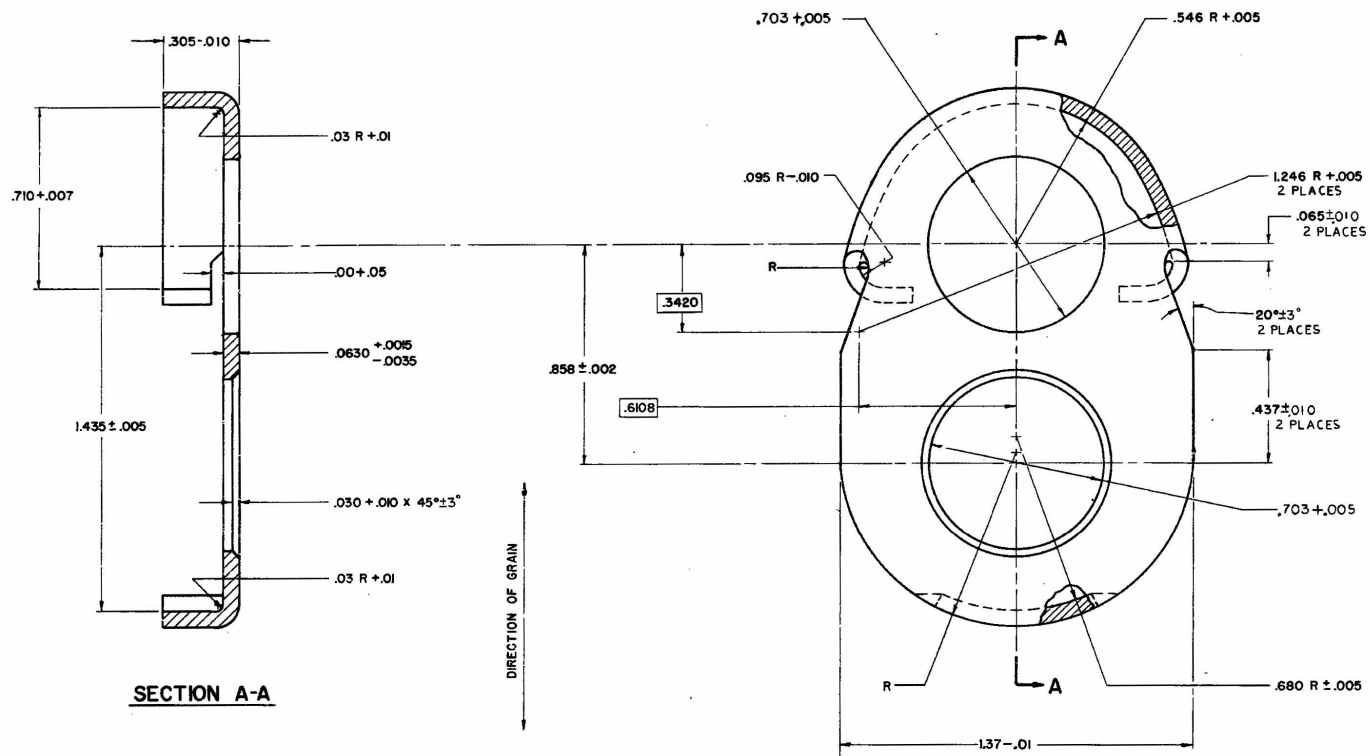
SCALE 3/1	UNIT WT.	SHEET
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ORIGINAL DATE OF DRAWING 82-06-01		U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801	
DRAWN BY ENGR		CHECKER ENGR	
ENGR		ENGR	
SIZE D		FSCM NO. 19200	
SCALE 3/1		UNIT WT.	
SHEET		9352724	

SCALE	2/1	UNIT WT	SHEET 1 OF
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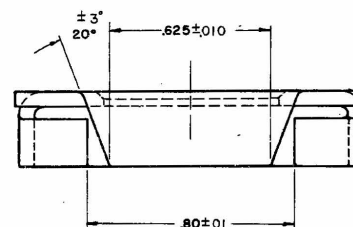






SECTION A-A

BAND, FRONT-9352725-2



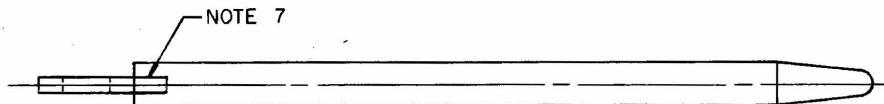
REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
XO			
-	PRODUCTION RELEASE ERR W2S 2025	84-04-20	<i>JS</i>
A	NORW452051 / 84-08-24 (ECPW552069 / 85-12-23)	86-01-21	<i>JS</i>

MECHANICAL PROPERTIES		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 82-06-01		U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801	
YP		TOLERANCES ON DECIMALS ± .01 FRACTIONS ± 1/64 ANGLES ± 3°		DRAFTSMAN <i>JS</i>	CHECKER	CYLINDER VALVE AND BAND ASSEMBLY	
TS				ENGR <i>JS</i>	ENGR	SIZE D	FSCM NO. 19200
EL2				ENGR <i>JS</i>	ENGR	SCALE 4/1	UNIT WT.
SA				SIGNATURE <i>L. Davis</i>		9352725	
BN				SIGNATURE <i>Edward J. Brown</i>		SHEET 3 OF 3	
RY	C-36-40						
NEXT ASSY		USED ON		APPLICATION			

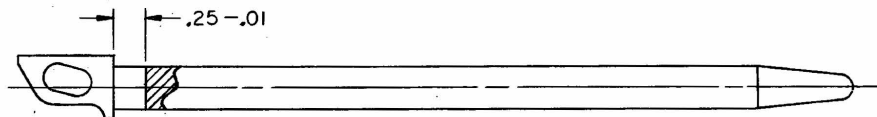
NOTES:-

- 1- SPEC MIL-W-13855 AND ANSI Y14.5-1973 APPLY.
- 2- MATERIAL:-CARBON TOOL STEEL, TYPE W1-09 THROUGH W1-12, ASTM A686.
- 3 FINISH 250/ EXCEPT AS NOTED
- 4-HEAT TREATMENT:- HEAT TO 1525°-1550° F. QUENCH IN CIRCULATING OIL. TEMPER 45 MINUTES MINIMUM TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED. SURFACE DECARBURIZATION SHALL NOT EXCEED .001 TOTAL.
- 5- ALL EDGES SHALL BE BROKEN .005±.015 UNLESS OTHERWISE SPECIFIED.
- 6- PROTECTIVE FINISH:-FINISH 5.3.1.2 OF MIL-STD-171.
- 7- BRAZE IN ACCORDANCE WITH SPEC MIL-B-7883, USING BRAZING ALLOY, COPPER, CLASS BCuZn-A, SPEC QQ-B-650 (NOTE 8,9).
- 8- TO INSURE OPTIMUM BRAZING STRENGTH. THE CLEARANCE BETWEEN THE PARTS TO BE BRAZED SHALL BE .002 TO .005. A FINE LINE OF BRAZING SHALL BE VISIBLE AROUND THE COMPLETE JOINT. BRAZING MATERIAL SHALL BE CONTROLLED TO PREVENT SPREADING OVER ADJACENT SURFACES.
- 9- AFTER BRAZING, BUT PRIOR TO APPLYING FINAL PROTECTIVE FINISH, REMOVE ALL EXCESSIVE BRAZING MATERIAL FROM THE AREAS ADJACENT TO THE JOINT.

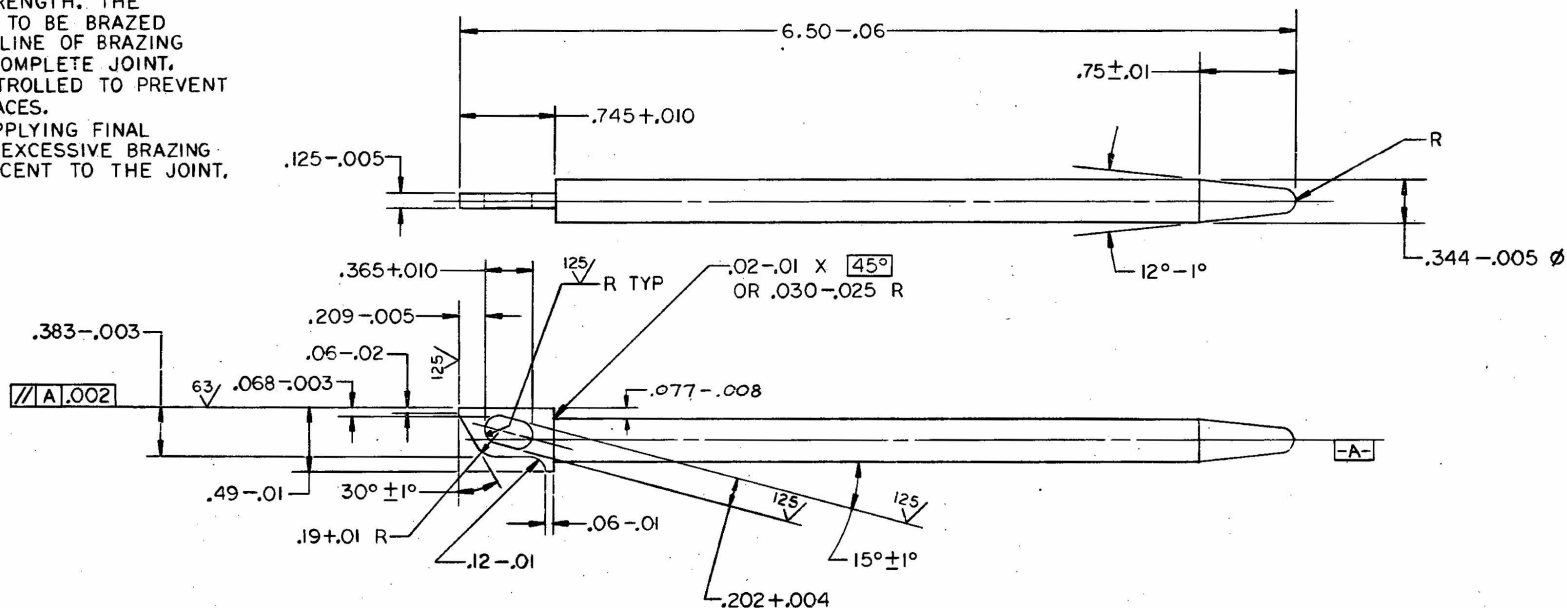
NOTE 7



.25 ±.01



ALTERNATIVE DESIGN



REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
XO			
-	PRODUCTION RELEASE ERR W2S 2025	8404 20	div
A	NORW452051 / 84 08 24 (ECPW552069 / 85 12 23)	8601 21	R/L Ben

PART NO. 9352726

J9386974		RIFLE, M14 NM		MECHANICAL PROPERTIES		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ± .01 FRACTIONS ± 1/64 ANGLES ± 1°		ORIGINAL DATE OF DRAWING 82-06-03		DRAFTSMAN J. Anis		CHECKER Charles J. Brown		U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801	
NEXT ASSY		USED ON		BH		C 50-55		ENGR		ENGR		ENGR		SCALE 2/1 UNIT WT.	
APPLICATION		SEE NOTE 4		RH				SIZE D		FSCM NO. 19200		9352726		SHEET 1 OF 1	

NOTES:-

- 1-SPEC MIL-W-13855 AND ANSI Y14.5-1973 APPLY.
  - 2-UPSET BOSS AT ASSEMBLY TO SECURE SAFETY SPRING.
- NOTE, SAFETY SPRING MUST BE FREE TO ROTATE ABOUT BOSS AFTER STAKING.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
XO			
-	PRODUCTION RELEASE ERR W2S2025	840420	JS
A	NORW4S2051/ 84 08 24 (ECPW5S2069 /85 12 23)	86 01 21	JS
B	ERR 2921248E (ECP G9S3062/890718)	900318	JS

HOUSING, HAMMER SPRING-8448292

PIN -7791367

SPRING-7267080

GUARD -7790990

NOTE 2

FIRING

TRIGGER ASSEMBLY -5546026

HAMMER-8448293

SPRING, HELICAL, COMPRESSION - 6008887

PLUNGER, HAMMER SPRING-8448692

PIN-5013668

HOUSING ASSEMBLY, TRIGGER-8448290

SAFETY-5546015

SAFE

RECOIL

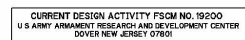
SEE SEPARATE PARTS LIST 9354354

PART NO. 9354354

MECHANICAL PROPERTIES		DO NOT SCALE DRAWING		ORIGINAL DATE OF DRAWING 82-06-01		U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801	
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAFTSMAN CHECKED			
9386973		TOLERANCES ON DECIMALS ±.01		ENGR A.L.S.		FIRING MECHANISM	
9386974 RIFLE M14NM		FRACTIONS ± 1/64 ANGLES ± 1°		ENGR W.B.		SIZE D FSCM NO. 19200 9354354	
NEXT ASSY USED ON				S. ARIAS		SCALE 2/1 UNIT WT SHEET	
APPLICATION				E. J. BRENNEN		SCANNED DUPLICATE ORIGINAL	

1 - SPEC MIL-W-13855 AND ANSI Y14.5-1973 APPLY.  
2 - PIN-MS51923-291 SHALL BE INSTALLED FLUSH  
OR BELOW BOTH SIDES.

NO	DESCRIPTION	DATE	BY
XO			
-	PRODUCTION RELEASE ERRW3S2005	830610	for R. [unclear]
A	NORW4S2051/840824 (ECPW5S2069/840824)	860121	



PART NO. 9362529

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER NEW JERSEY 07801

BARREL ASSEMBLY

		<b>DO NOT WRITE IN THESE SPACES</b>		ORIGINAL DATE OF DRAWING 82-03-OF		PART NO: 9362529	
		REVISIONS		CAPTAIN		U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOWDY NEW JERSEY 07061	
		APPROVED BY		MAJOR		BARREL ASSEMBLY	
7791363		RIFLE M14-NV		SERIAL NO.		SIZE F	
NEXT ASSY		USED ON		DATE		FSCM NO. 19200	
APPLICATION				DRAWN BY		9362529	
				CHECKED BY		SCALE 1/1 UNIT WT SHEET 1 OF 1	

1-BEDDING MATERIAL:-  
BISONITE RIFLE BEDDING R188B  
AVAILABLE AT:  
H & S PRECISION, INC.  
P.O. BOX 512  
PRESCOTT, AZ 86302

- 14-REWORKING, PATCHING, OR OTHERWISE REPAIRING THE STOCK BEDDING IS NOT PERMISSIBLE.

#### 15-FINISH OF STOCK AFTER BEDDING:

PROTECTIVE FINISH AND COLOR:

- A-FINAL PROTECTIVE FINISH:-FINISH 29.7 OF MIL-STD-171 (DIPPED A MINIMUM OF 3 MINUTES)  
B-NO AREAS SHALL BE LIGHTER THAN THE APPLICABLE COMPARISON COLOR GAGE:

TYPE I WOOD: COMPARISON GAGE NO 11018988-W  
TYPE II WOOD: COMPARISON GAGE NO 11018988-B

C-PRIOR TO APPLICATION OF FINAL PROTECTIVE FINISH  
SHALL BE STAINED USING A SPIRIT BASE STAIN.

- C-PRIOR TO APPLICATION OF FINAL PROTECTIVE FINISH, LIGHT AREAS SHALL BE STAINED USING A SPIRIT BASE STAIN, AS NECESSARY, TO MEET THE SPECIFIED COLOR REQUIREMENT.


- 16-AFTER APPLICATION OF PROTECTIVE FINISH,STOCKS SHALL BE FREE  
CRACKS,SPOTS,GLOSSY PATCHES,LIGHT STREAKS,RUNS,CONTACT MARKS,STICKINESS  
AND CRAZING.EXTERIOR STOCK CONTOUR SHALL BE SMOOTH AND EXHIBIT NO BUILD-  
UP OR RAISED GRAIN.



**PART NO. 9381705**

[illegible]

## NOTES: -

1-AREAS MARKED WITH  PERMISSIBLE TO BE ROUTED DURING GLASS BEDDING PROCEDURES, ROUT AS REQUIRED TO PROVIDE ACCEPTABLE GLASS BEDDING MATERIAL THICKNESS.

2-SPEC MIL-W-13855 SHALL APPLY.

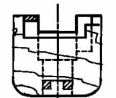
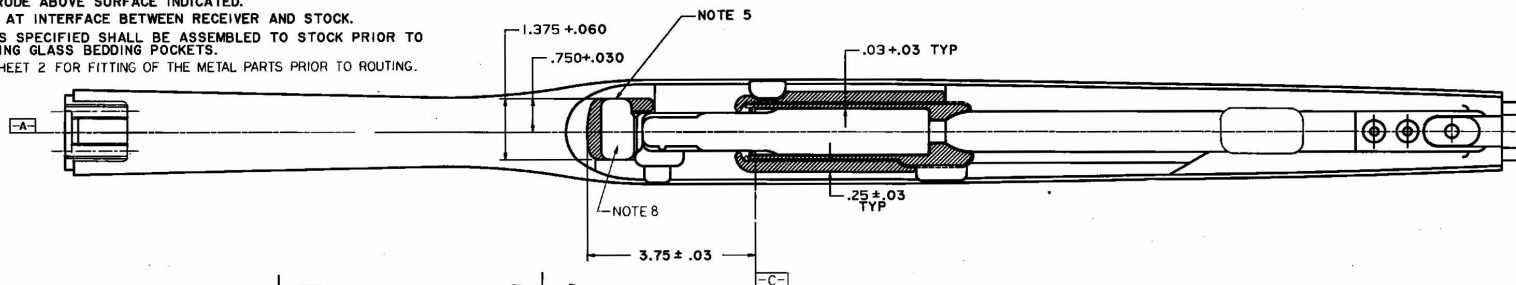
3-ATTACH FERRULE USING THE BEDDING MATERIAL IN NOTE 1 OF DWG F9381705. TOP OF FERRULE TO BE FLUSH WITH TOP OF STOCK.

4-SET END OF RIVETS SHALL BE FREE OF CRACKS AND SHALL NOT PROTRUDE ABOVE SURFACE INDICATED.

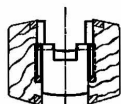
5-ROUT AT INTERFACE BETWEEN RECEIVER AND STOCK.

6-PARTS SPECIFIED SHALL BE ASSEMBLED TO STOCK PRIOR TO ROUTING GLASS BEDDING POCKETS.

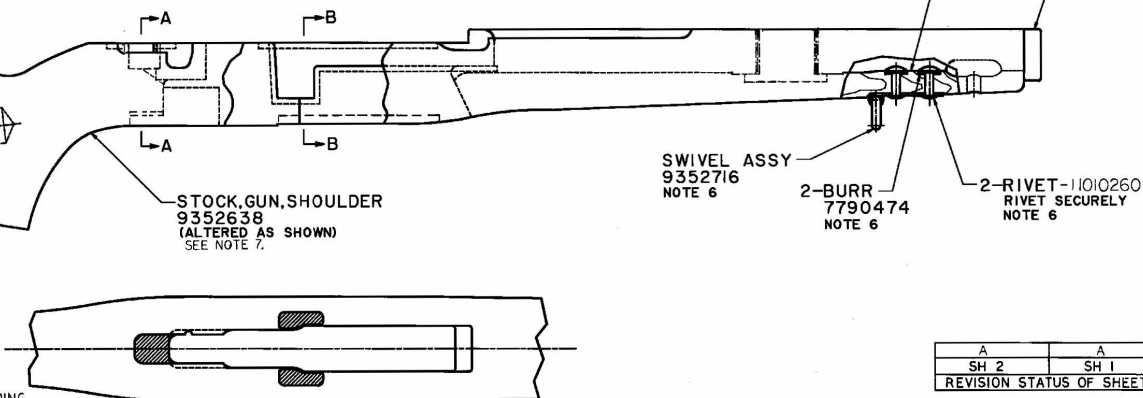
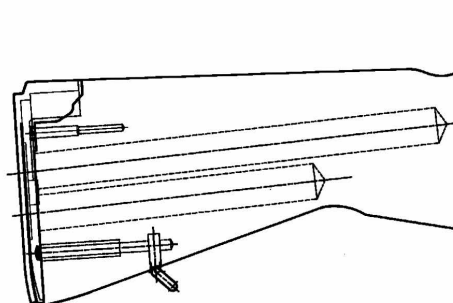
7-SEE SHEET 2 FOR FITTING OF THE METAL PARTS PRIOR TO ROUTING.



SECTION A-A



SECTION B-B



8- THIS CAVITY MAY BE PARTIALLY FILLED-IN WITH WOOD BLOCK(S) (ALONG BOTH SIDES OF THE STOCK) AS REQUIRED TO PROVIDE BEDDING TO FACILITATE USE OF THIS STOCK WITH BARREL AND RECEIVER ASSEMBLIES WHICH PRE-DATE THE INCLUSION OF RECOIL LUG 9352637. WOOD BLOCKS MUST BE PERMANENTLY ATTACHED (GLUED) TO THE BASE STOCK.

REV	DESCRIPTION	DATE	APPROVAL
X0	PRODUCTION RELEASE SEE EHR WAS 2051/840835 (ECP W55X081/ 851223)	860121	SM
A	NOR G753187/871221 (ECP 6853002/860216)	880712	SM

A	A
SH 2	SH 1
REVISION STATUS OF SHEETS	

PART NO. 9381706		U S ARMY AMMUNITION RESEARCH AND DEVELOPMENT CENTER CAMP BERRYVILLE	
STOCK, SUBASSEMBLY GUN, SHOULDER		F 19200 9381706	
SCALE 1/1		SHEET 1 OF 2	

APPLICATION	9382337	DE-44M RIFLE	USED IN	84-05-09	84-05-09	84-05-09	84-05-09
DESIGNED BY	DESIGNED BY	DESIGNED BY	DESIGNED BY	DESIGNED BY	DESIGNED BY	DESIGNED BY	DESIGNED BY
CHECKED BY	CHECKED BY	CHECKED BY	CHECKED BY	CHECKED BY	CHECKED BY	CHECKED BY	CHECKED BY
APPROVED BY	APPROVED BY	APPROVED BY	APPROVED BY	APPROVED BY	APPROVED BY	APPROVED BY	APPROVED BY

[illegible]

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[illegible]

U S ARMY ARMAMENT RESEARCH AND DEV

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100
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1	10200	
SCALE 1/1	UNIT WT	UNIT 2

DATE	1/1/19	TIME	10:00	LOCATION	2
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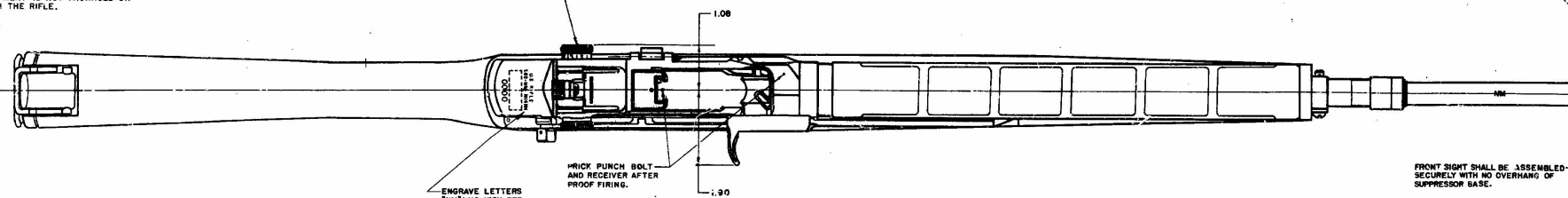
4. FOR INFORMATION ONLY:  
SUPPORT EQUIPMENT IS LISTED ON DWG 12002927.  
SUPPORT EQUIPMENT IS NOT PACKAGED OR  
INCLUDED WITH THE RIFLE.

J 9 8 6 7 4  
S H 1 4  
F 1 / 2

**SIGHT MUST BE FREE OF EXCESS OIL.**

THE FLASH SUPPRESSOR SHALL BE FASTENED WITH NO ROTATIONAL OR LONGITUDINAL, IN ASSEMBLY THE NUT WITH EVENLY SP, ROTATED IN A CLOCKWISE DIRECTION, ON THE MAXIMUM TIGHTNESS AGAINST FLASH SURF AND POSITIONING ONE OF THE NOTCHES AT POSITION. THE NUT SHALL NOT BE BACKED UP THE NUT SHALL BE LOCKED SECURELY BY EITHER GAGE 1015429 OR 1015430 SW UP TO THE HANDLE OF THE GAGE AND THE NUT SHALL NOT TOUCH THE FLASH SUPPRESSOR. BE USED WHEN THE BORE DIA IS .3005 OR SHALL BE USED WHEN THE BORE DIA IS .30 SUPPRESSOR SHALL BE SELECTIVELY ASSIGNED TO REQUIREMENT.

FRONT SIGHT SHALL BE ASSEMBLED—  
SECURELY WITH NO OVERHANG OF  
SUPPRESSOR BASE.



WITH THE FIRING MECHANISM, STOCK ASSEMBLY, OPERATING ROD SPRING AND SPRING GUIDE DISASSEMBLED FROM THE RIFLE, AND WITH THE MUZZLE RAISED TO AN ANGLE OF APPROXIMATELY 60° FROM THE HORIZONTAL, THE BOLT, WITH OPERATING ROD ASSEMBLED, SHALL OPEN FULLY WITHOUT ANY MANUAL ASSISTANCE. WHEN THE MUZZLE IS LOWERED TO AN ANGLE OF APPROXIMATELY 80° FROM THE HORIZONTAL, THE BOLT, WITH OPERATING ROD ASSEMBLED, SHALL CLOSE FULLY WITHOUT ANY MANUAL ASSISTANCE.

ENGRAVE LETTERS  
"NM" 1/16 HIGH PER  
MIL-STD-130

PRICK PUNCH BOLT-  
AND RECEIVER AFTER  
SHOOTING

— 44.28

26.75 APPROX  
SIGHT RADIUS AT  
100 METER SETTING

GAS CYLINDER SHALL BE BROUGHT FORWARD AGAINST THE LOCK BEFORE TIGHTENING THE CYLINDER PLUG.

STOCK FERRULE SHALL CONTACT  
LOWER PORTION OF FRONT BAND-  
(SEE SMT 2, NOTE 8)

✓ THERE SHALL BE APPROXIMATELY  
1/64 MIN CLEARANCE.

— SAFETY SHALL HAVE UNRESTRICTED MOVEMENT WITH POSITIVE RETENTION IN LOCKING OF HAMMER AND FREE MOVEMENT OF HAMMER WHEN SAFETY IS RELEASED.

[illegible]

MECHANISM, STOCK ASSEMBLY, OPERATING ROD SPRING  
ASSEMBLED FROM THE RIFLE, AND WITH THE  
AN ANGLE OF APPROXIMATELY 60° FROM THE  
BOLT, WITH OPERATING ROD ASSEMBLED, SHALL OPEN FULLY  
W. ASSISTANCE WHEN THE MUZZLE IS LOWERED TO  
APPROXIMATELY 60° FROM THE HORIZONTAL, THE BOLT, WITH  
SEMBLED, SHALL CLOSE FULLY WITHOUT ANY MANUAL

— THE APERTURE ASSEMBLY PROVIDES 1/2 MINUTE OF ANGLE/ELEVATION ADJUSTMENT. THE PEEPHOLE SIZE SHALL BE .0095 DIA. FOR APERTURE ASSET 779133

THE BASE/REAR SIGHT PROVIDES 1/2 MINUTE ANGLE OF WINDAGE ADJUSTMENT.

REAR SIGHT MARKINGS MUST BE DISTINCT.

ELEVATING KNOB MUST BE ON 100 METER SETTING WHEN APERTURE IS ELEVATED 6 CLICKS FROM LOWEST POSITION.

KNOBS MUST HAVE FREE MOVEMENT, INDEPENDENT OF EACH OTHER, DEFINITE CLICKING ACTION; AND POSITIVE RETENTION.

APERTURE ASSEMBLY SHALL OPERATE SMOOTHLY IN BASE/REAR SIGHT WITH NO PERCEPTIBLE SIDE MOVEMENT WHEN SET AT 600 METER SETTING.

— PERCEPTUAL ASSEMBLY SHALL BE IN BASE/REAR ASSEMBLY AND BASE/REAR SIGHT SHALL BE EFFECTED AS NECESSARY TO MEET ABOVE REQUIREMENTS.

WHEN NECESSARY EQUAL AMOUNTS OF MATERIAL SHALL BE REMOVED FROM BOTH SIDES OF APERTURE TO OBTAIN THE REQUIRED FIT.

— PERCEPTUAL ASSEMBLY SHALL BE FITTING THE APERTURE ARE PERMISSIBLE.

WHEN APERTURE ASSEMBLY IS ELEVATED TO ITS HIGHEST POSITION AND THUMB PRESSURE IS APPLIED TO BOTTOM OF EYEPIECE IN A VERTICAL PLANE AWAY FROM THE PERCEPTUAL POSITION OF COVER MUST RETURN THE APERTURE ASSEMBLY TO ITS ORIGINAL POSITION.

SIDE/REAR SIGHT SHALL BE TIGHTENED WITHIN 20 TO 25 INCH LBS.

SIGHT MUST BE FREE OF EXCESS OIL.

THE FLASH SUPPRESSOR SHALL BE FASTENED TO THE BARREL WITH NO ROTATIONAL OR LONGITUDINAL MOVEMENT.

IN ASSEMBLY THE NUT WITH EVENLY SPACED NOTCHES SHALL BE ROTATED IN A CLOCKWISE DIRECTION SIMULTANEOUSLY ACHIEVING MAXIMUM TIGHTENING OF THE NOTCHES AND THE FLASH SUPPRESSOR AND POSITIONING ONE OF THE NOTCHES AT THE TWELVE O'CLOCK POSITION. THE NUT SHALL NOT BE BACKED OFF TO ALIGN A NOTCH. THE NUT SHALL BE LOCKED SECURELY BY THE SET SCREW.

EITHER CASE .1015429 OR .1015430 SHALL ENTER THE MUZZLE IN THE BORE DIA. 1.3000 OR SMALLER, AND THE SET SCREW SHALL NOT TOUCH THE FLASH SUPPRESSOR. CASE .1015429 SHALL BE USED WHEN THE BORE DIA IS .3000 OR SMALLER, CASE .1015430 SHALL BE USED WHEN THE BORE DIA IS .3006 OR LARGER. FLASH SUPPRESSOR SHALL BE SELECTIVELY ASSEMBLED TO ACHIEVE ABOVE REQUIREMENT.

FRONT SIGHT SHALL BE ASSEMBLED  
SECURELY WITH NO OVERHANG OF  
SUPPRESSOR BASE.

STOCK FERRULE SHALL CONTACT  
LOWER PORTION OF FRONT BAND-  
(SEE SMT 2, NOTE 8)

— THERE SHALL BE APPROXIMATELY  
1/64 MIN CLEARANCE.

GAS CYLINDER SHALL FIT TIGHTLY ON THE BARREL DIAMETER AND THE SPLINES.THERE SHALL BE NO ROTATIONAL MOVEMENT.PEENING OF GAS CYLINDER SPLINES IS PERMISSIBLE TO MEET REQUIRED FIT.

IN ASSEMBLY,THE GAS CYLINDER LOCK SHALL BE HAND TIGHTENED AGAINST SHOULDER ON THE BARREL WITHIN A RANGE BEYOND THE 6 O'CLOCK POSITION BUT NOT IN EXCESS OF 210° (1 O'CLOCK) PAST THE 6 O'CLOCK POSITION,THE GAS CYLINDER LOCK SHALL THEN BE "BACKED OFF" THE MINIMUM DISTANCE NECESSARY TO ALIGN WITH THE GAS CYLINDER AT THE 6 O'CLOCK POSITION.

GAS CYLINDER SHALL BE BROUGHT FORWARD AGAINST THE LOCK BEFORE TIGHTENING THE CYLINDER PLUG.

— SAFETY SHALL HAVE UNRESTRICTED MOVEMENT WITH POSITIVE RETENTION IN LOCKING OF HAMMER AND FREE MOVEMENT OF HAMMER WHEN SAFETY IS RELEASED.

REVISIONS			
NO.	DESCRIPTION	DATE	APPROVAL
XO			
-	PRODUCTION RELEASE SEE ERR W452081 / 8408 24 ICP W552069R1 85 12 23	850121	R1

**F 2 / 2**

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SHT. 4	SHT. 3	SHT. 2	SHT.
REVISION STATUS OF SHT'S			

PART NO.

RIFLE, 7.62 MM  
M14 NATIONAL MATCH

DATE	FSCN NO.	
1	19200	9386974

SCALE	1/1	UNIT WT		THICKNESS	1.0
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[illegible]

AFR 888 Form 75, 1 July 70

1000-S-R 9

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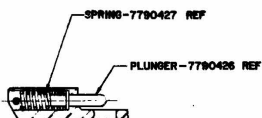
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4

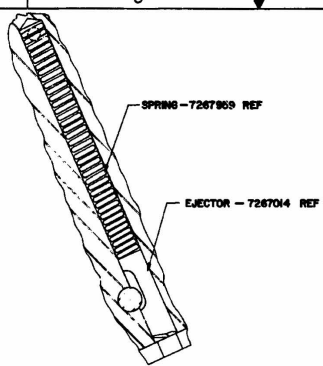
3

2

J 8 6  
S H 2 4  
F / 2



SECTION H-H  
(SHEET 1)



PARTIAL SECTION D-D

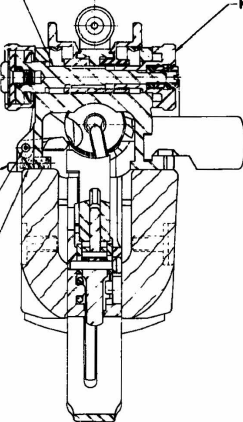
PINION ASSY-11010363

KNOB ASSY-7790386

STOP-7267034

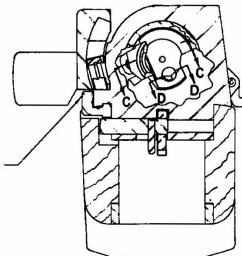
PIN-MS16562-124  
OR MS51923-422

SPRING-7267074

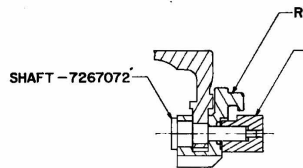


SECTION A-A  
(SHEET 3)

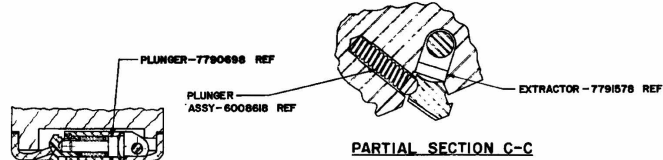
CONNECTOR ASSY-7790424



SECTION B-B  
(SHEET 3)



PARTIAL SECTION SHOWING PARTS ASSEMBLED  
FOR SEMIAUTOMATIC FIRE ONLY. REF DWG 92



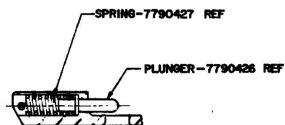
PARTIAL SECTION C-C

PARTIAL SECTION F-F

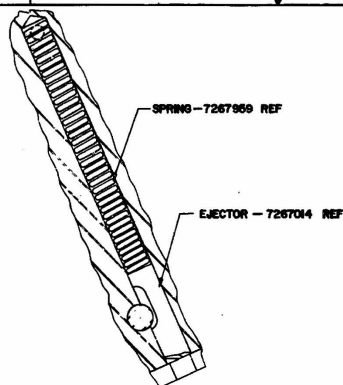
MECHANICAL PROPERTIES		DO NOT SCALE DIMENSIONS	
YIP	UNLESS OTHERWISE SPECIFIED	TOLERANCES ON DIMENSIONS	IN INCHES
TS		FRACTIONS	ON DECIMALS
EQ		FRACTIONS	ON ANGLES
EX			
RY			
RI			
APPLICATION			

REVISIONS			
ITEM	DESCRIPTION	DATE	APPROVAL
1	PRODUCTION RELEASE SEE ERMW5205 / 940501	960121	
2	REL PWS52059R / 851223		

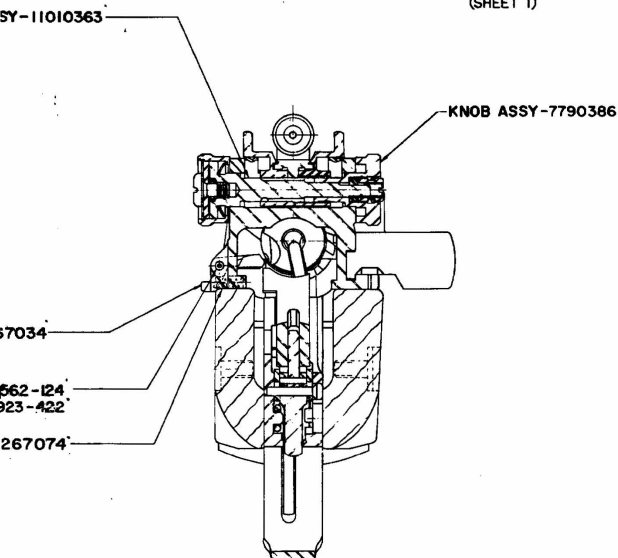
**F 2 / 2**



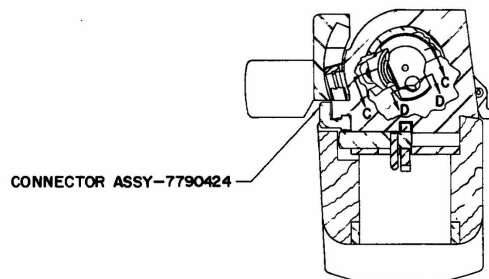
**SECTION H-H**  
(SHEET 1)



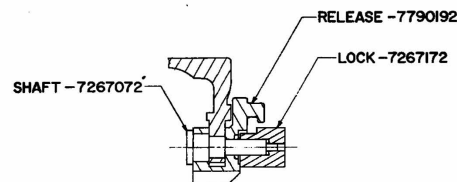
**PARTIAL SECTION D-D**



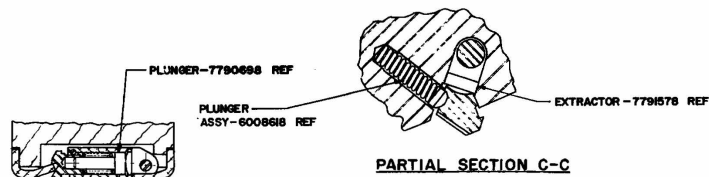
**SECTION A-A**  
(SHEET 3)



**SECTION B-B**  
(SHEET 3)



PARTIAL SECTION SHOWING PARTS ASSEMBLED AND WELDED FOR SEMIAUTOMATIC FIRE ONLY. REF DWG 9352636



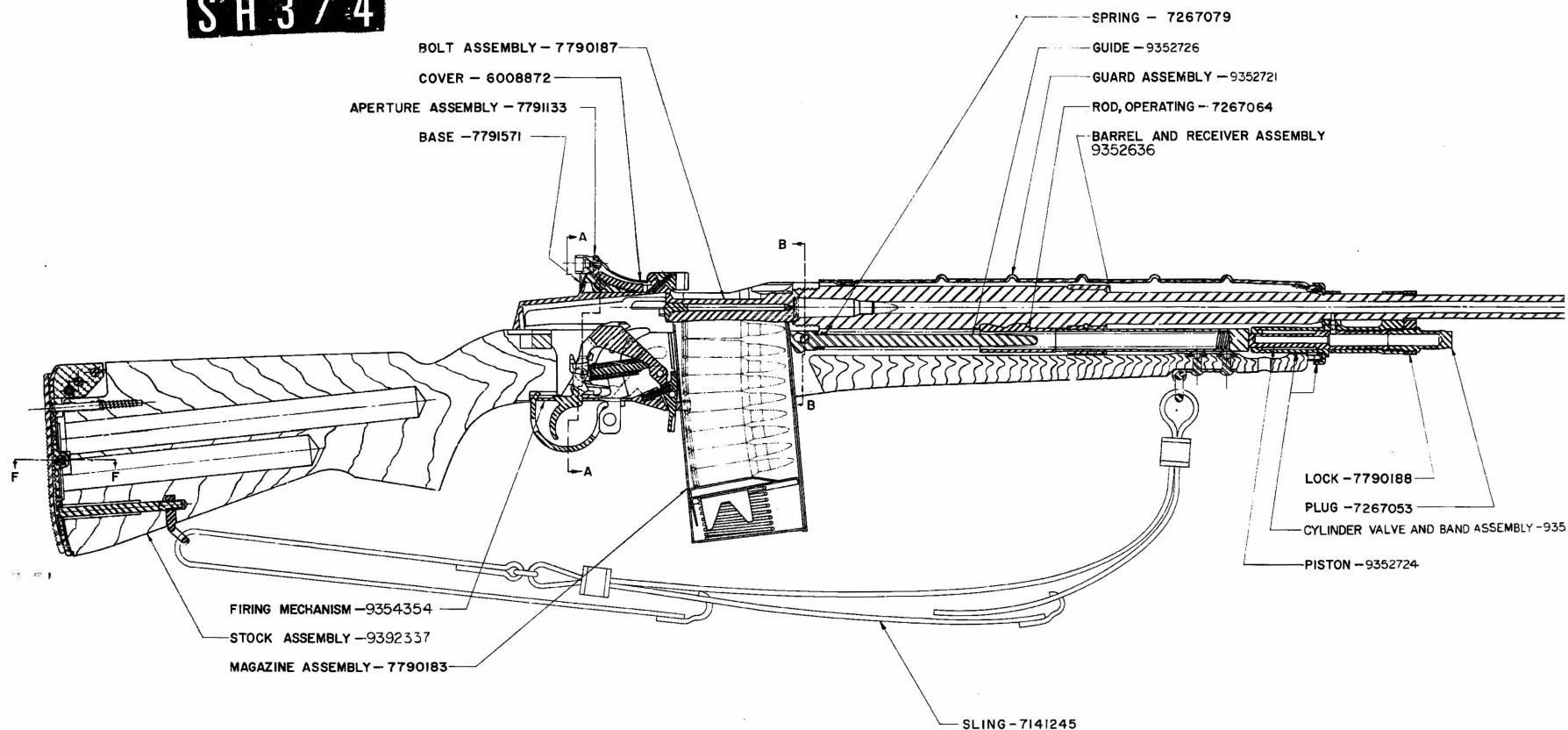
**PARTIAL SECTION C-C**

**PARTIAL SECTION F-F**

<b>MECHANICAL PROPERTIES</b> TYPE: _____ TENSILE: _____ ELONGATION: _____ HARDNESS: _____ THERMAL: _____ CORROSION: _____ WELDING: _____ APPLICATION: _____		<b>DO NOT SCALE DIMENSIONS</b> UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS: FRACTIONS: _____ ANGLES: _____	<b>ORIGINAL DATE OF REVISION</b> 04-08-21 DESIGNED BY: _____ CHECKED BY: _____ ENGINEER: _____ DRAWN BY: _____ APPROVED BY: _____ SPECIAL INSTRUCTIONS: _____	<b>PART NO.</b> 9386974 <b>RIFLE, 7.62MM</b> <b>M14 NATIONAL MATCH</b> SIZE: J FSCM NO. 19200 9386974 SCALE: 2/1 UNIT: WT SHEET 2 OF 4
---	--	---	--	--

8 7 6 5 4 3 2 1

J 9 3 8 6 9 7 4  
F 1 / 2  
S H 3 / 4



MECHANICAL PROPERTIES		DO NOT SCALE DRAWING		ORIGINAL DATE
ITEM	PROPERTY	UNLESS OTHERWISE SPECIFIED	UNLESS OTHERWISE SPECIFIED	
1	YF	DIMENSIONS ARE IN INCHES		84-
2	TS			DISSEMINATION
3	SLF	TOLERANCES ON DECIMALS =		END
4	SA	FRACTIONS =	ANGLES =	STOCK
5	SA			STOCK
6	SA			STOCK
7	SA			STOCK
8	SA			STOCK
9	SA			STOCK
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8

7

6

5

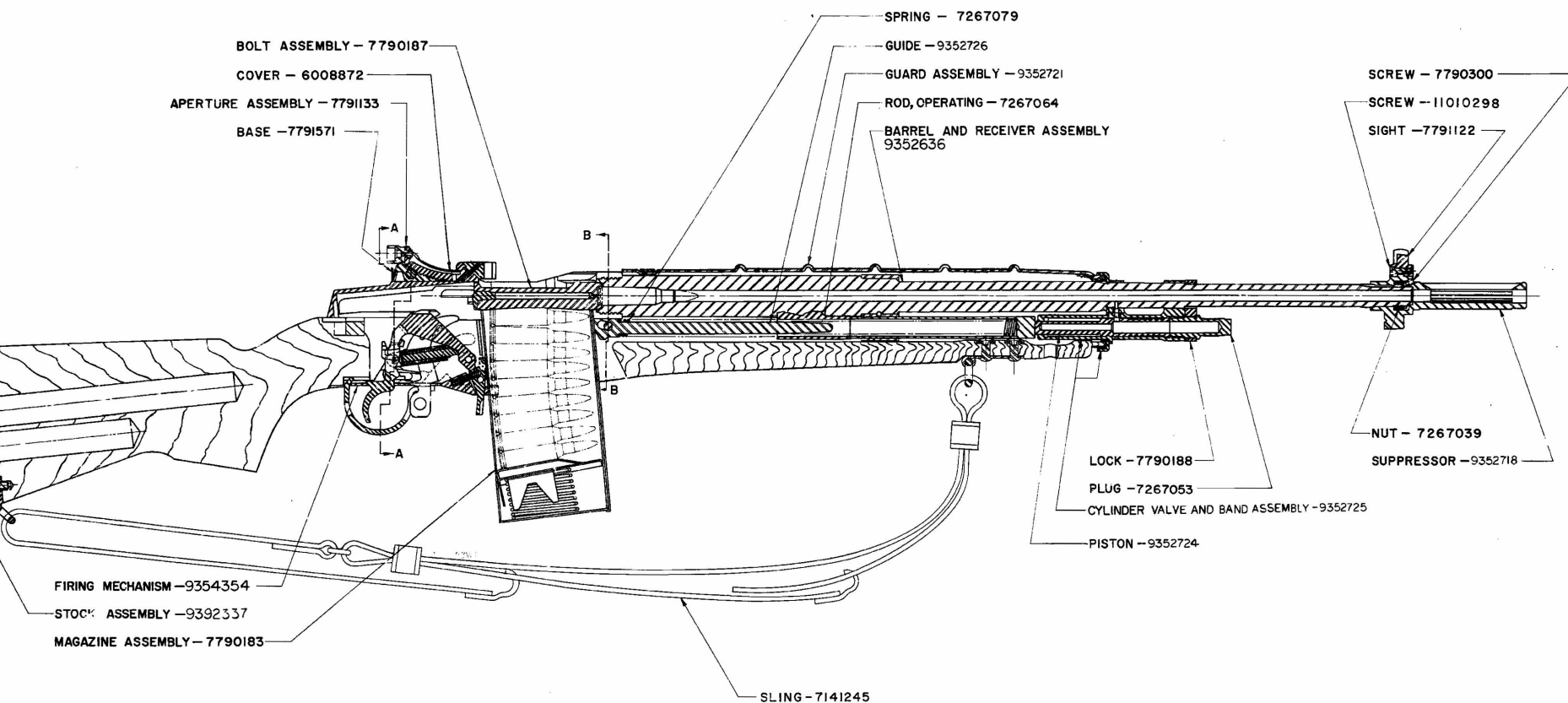
4

3

2

REVISIONS			
NO.	DESCRIPTION	DATE	APPROVAL
1	PRODUCTION RELEASE SEE EAW W452051/840824 ECP W452051/851223	860121	411

F2/2



PART NO.

MECHANICAL PROPERTIES		DO NOT SCALE DRAWING		ORIGINAL DATE OF DRAWING		U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER NEW JERSEY 07801	
TYPE	TS	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		84-05-21		RIFLE, 7.62MM M14 NATIONAL MATCH	
SIZE	TS	TC: HANCES ON DECIMALS #		DRAWN BY	CHECKER	SCALE	FSCM NO.
FRS	TS	FRACTIONS #	ANGLES #	ENG	ENGR	19200	9386974
9386974	M14 SNIPER RIFLE						
NEXT ASSY	USED ON						
APPLICATION							

SCALE 1/1 UNIT IN SHEET 3 OF 4

RIFLE COOKED

SAFETY IN FORWARD POSITION

WIRE PARALLEL WITH BARREL AND PERPENDICULAR TO GROUND.

WIRE FREE

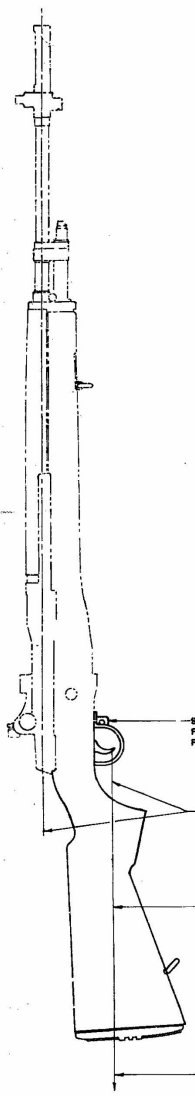
APPROVED MEASURING DEVICE

TH  
TH  
TH  
P.C  
SU  
TH



F 2 / 2

REVISIONS			
REV	DESCRIPTION	DATE	APPROVAL
20	PRODUCTION RELEASE SEE ESR W452051 / 840824 (ELP W552059H / 85/243)	860121	1



RIFLE COCKED

SAFETY IN FORWARD POSITION

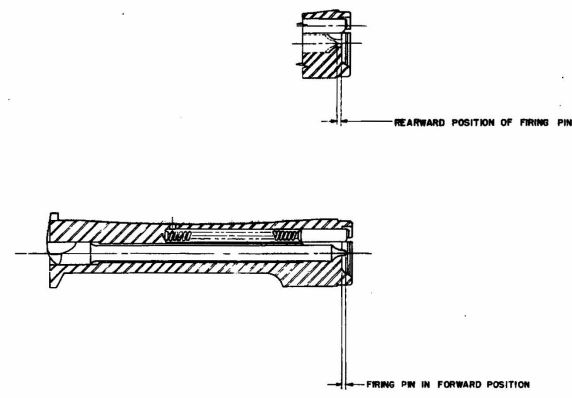
WIRE PARALLEL WITH BARREL AND PERPENDICULAR TO GROUND.

WIRE FREE

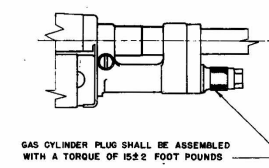
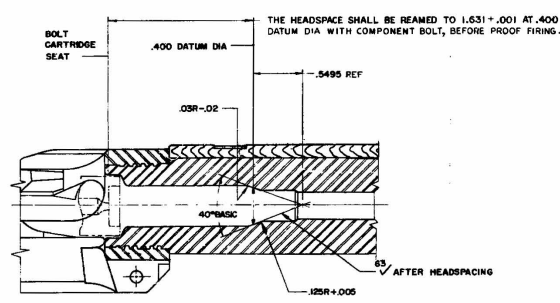
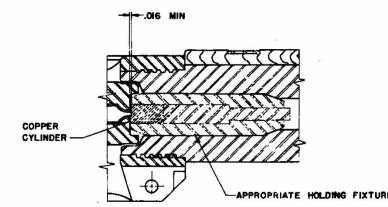
APPROVED MEASURING DEVICE

THE TRIGGER PULL (PARALLEL TO & OF BORE) REQUIRED TO RELEASE THE HAMMER SHALL BE SMOOTH, FREE FROM "CREEP" AND WITHIN THE LIMITS OF FOUR AND ONE-HALF TO FOUR AND THREE-QUARTER POUNDS. FRONT AND REAR HAMMER HOOKS AND MATING SURFACES OF THE TRIGGER SHALL BE ALTERED BY STONING TO MEET THE REQUIRED TRIGGER PULL.

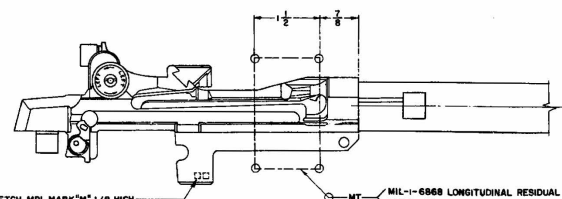
VIEWS SHOWING LIMITS OF FIRING PIN POSITIONS  
(BOLT OUT OF RIFLE)  
(SEE DWG C7790187 FOR REQUIREMENTS)



FIRING PIN INDENT SHALL BE TAKEN IN SOFT, ANNEALED, 99.90% PURE COPPER COMPRESSION CYLINDERS (GOVERNMENT STANDARD) AND SHALL NOT BE OFF CENTER MORE THAN ONE-HALF THE DIAMETER OF THE FIRING PIN POINT.



SCALE 1/1



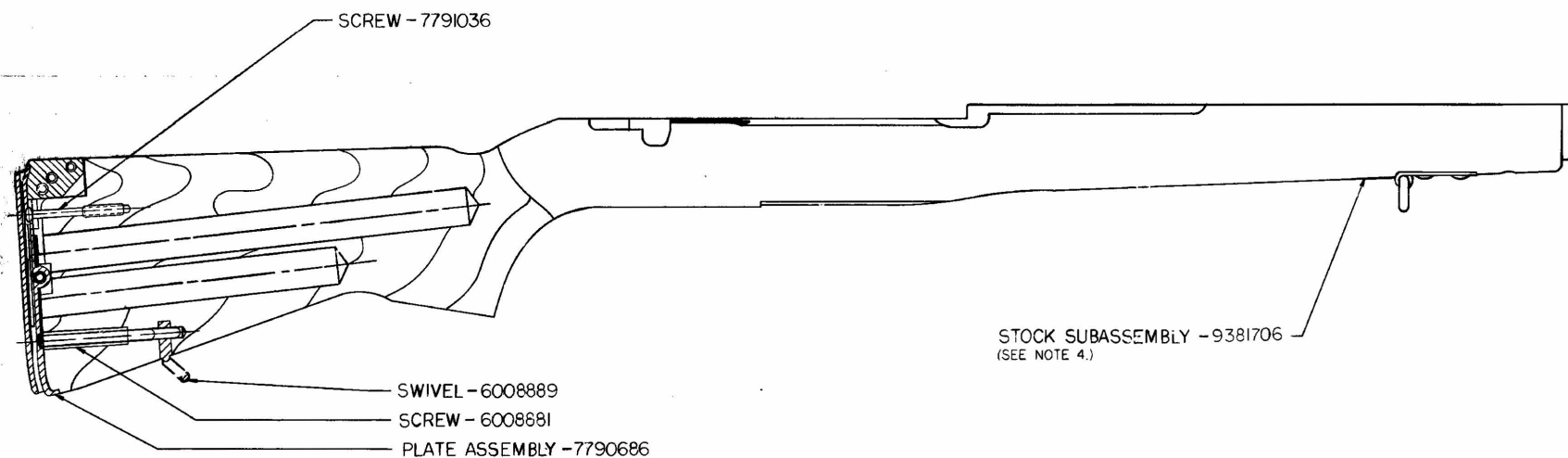
NOTE: AFTER COMPLETION OF ALL FIRING TESTS (HIGH PRESSURE RESISTANCE, FUNCTION FIRING AND TARGETING AND ACCURACY) PER SPEC MIL-R-45979, EACH RECEIVER SHALL BE FREE FROM CRACKS, SEAMS, AND OTHER MAJOR DEFECTS AS DETERMINED BY MAGNETIC PARTICLE INSPECTION USING A STANDARD 9 TURN MAGNETIZING COIL WITH A CURRENT OF 800 TO 1200 AMPERES. APPLY MPI MARK TO RIFLES MEETING THIS REQUIREMENT. APPLICATION AND REMOVAL OF THE WET FLUORESCENT SOLUTION SHALL BE CONTROLLED TO PREVENT CONTAMINATION IN AREAS OF REAR SIGHT, BOLT STOP, SEAR RELEASE AND CARTRIDGE CLIP GUIDE. ADEQUATE CONTROL SHALL ALSO BE MAINTAINED TO MINIMIZE CONTAMINATION IN AREAS OF BARREL AND RECEIVER THREADS AND CONNECTOR LOCKING PIN.

APPLICATION		MECHANICAL PROPERTIES		DO NOT SCALE DRAWING		ORIGINAL DATE OF DRAWING		PART NO.	
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES				84-09-21		U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER	
		TOLERANCES ON DECIMALS				CHECKED		OWNER NEW JERSEY STATE	
		FRACTIONS				DESIGNED		RIFLE, 762MM	
		ANGLES				DRAWN		MI4 NATIONAL MATCH	
						EDUCATION			
						J		19200	
						SCALE 1/1		9386974	
						SHEET 1/1		SHEET 4 OF 6	

NOTES -

1. ALL SCREWS SHALL BE TIGHTENED SECURELY.
2. MIL-W-13855 SHALL APPLY.
3. PLATE ASSEMBLY - 7790686 MAY REQUIRE DRILLING AND FITTING AT ASSEMBLY FOR DETAIL SEE DWG-9352638.
4. SEE DWG-9381705 FOR BARREL TO STOCK BEDDING.

REVISIONS			
BYN	DESCRIPTION	DATE	APPROVAL
XO			
-	PRODUCTION RELEASE SEE ERM WAS8091/840824 (ECP W552069N / 85 12 23)	860121	<i>Am</i>



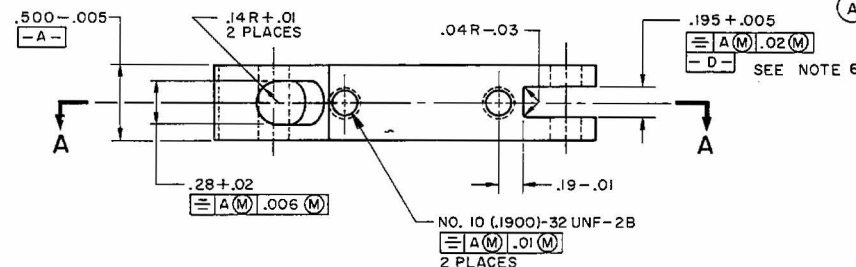
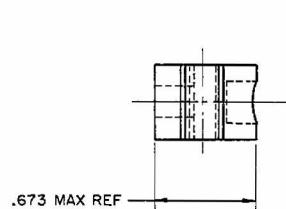
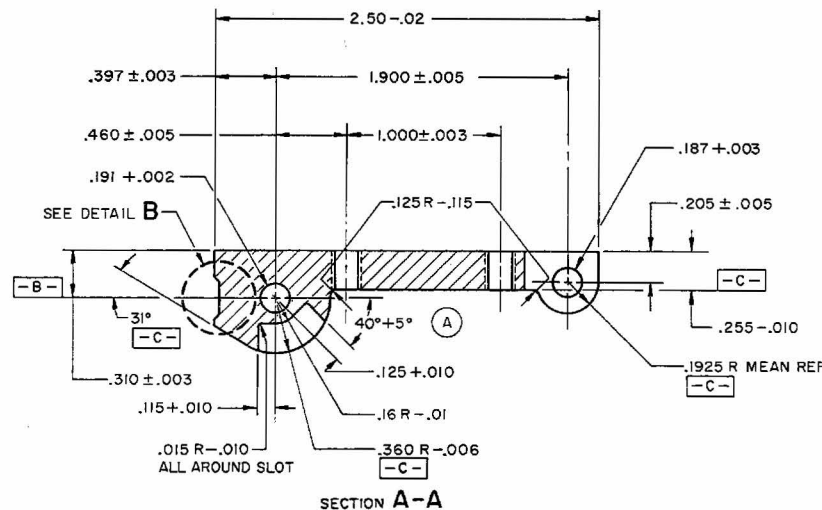
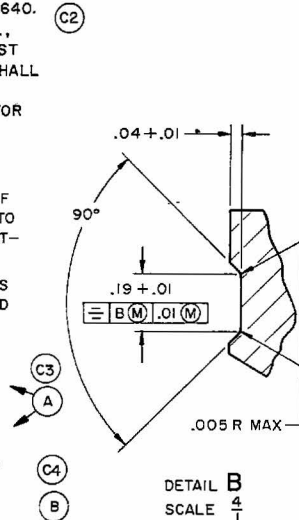
9386974		M4 NM RIFLE		NEXT ASSY		USED ON		APPLICATION		MECHANICAL PROPERTIES		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ±: FRACTIONS ±: ANGLES ±:		ORIGINAL DATE OF DRAWING 84-05-09 DRAFTSMAN: <i>Ed</i> CHECKER: <i>Ed</i> ENGR: <i>Ed</i> ENGR: <i>Ed</i>		U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801	
THIRD ANGLE PROJECTION										SCALE 1/1		UNIT WT.		SHEET 1 OF 1			
F										FSCM NO. 19200		9392337					



NOTES:

1. FINISH 125.
2. ALL EDGES AND CORNERS SHALL BE BROKEN .005 + .010 UNLESS OTHERWISE SPECIFIED.
3. MATERIAL: STEEL, FED. STD 66-8640. FOR INVESTMENT CASTING: STEEL, MIL-S-22141-IC-8640. TENSILE TEST SHALL NOT APPLY. INSPECTION SHALL BE IN ACCORDANCE WITH SPEC MIL-C-6021. SEE DWG B11010087 FOR RADIOGRAPHIC POSITION CHART.
4. HEAT TREATMENT: HEAT AT 1540°F TO 1580°F. OIL QUENCH. TEMPER TO SPECIFIED HARDNESS. HEAT TREATMENT METHOD IS FOR GUIDANCE.
5. EXTERIOR EDGES ALONG SURFACES LABELED **-C-** SHALL BE ROUNDED TO .03R + .03.
6. **-D-** MAY BE ADJUSTED TO MEET ASSEMBLY REQUIREMENTS SPECIFIED ON DWG B11010044.

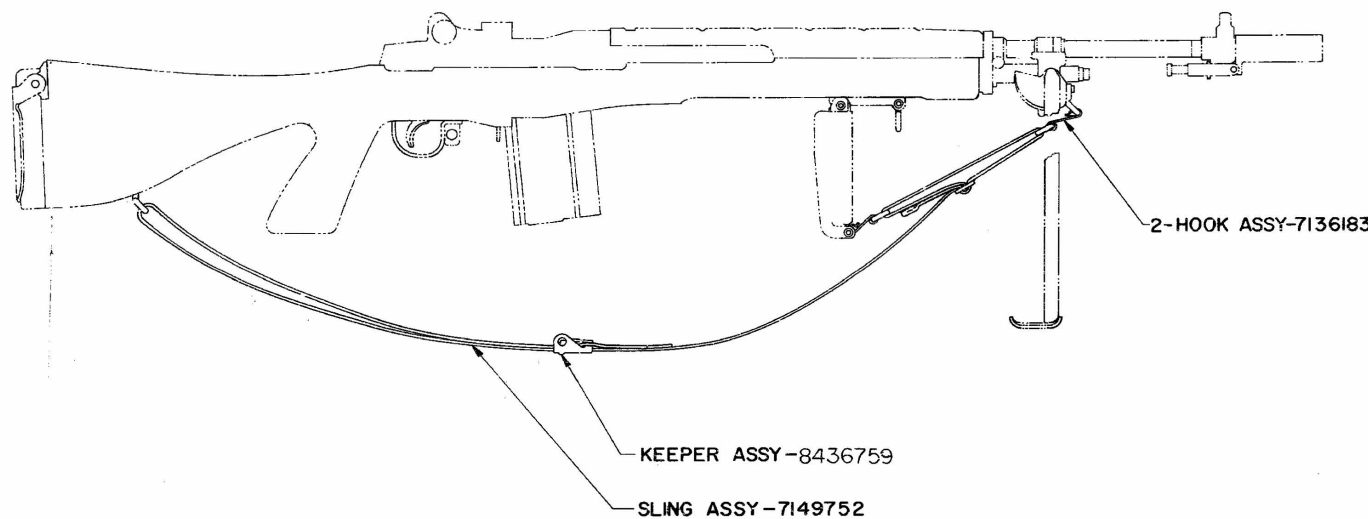
REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
A4	SEE EO SA 27239	21 NOV 63	
B2	SEE EO SA 27239	6 NOV 64	
C	(1-4) SEE EO SA 29262	18 MAY 66	



MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING		PART NO. 11010004	
YP	B11010044	RIFLE, M14E2	TOLERANCES ON DIMENSIONS ±	23 OCT 63	SPRINGFIELD ARMY U.S. ARMY WEAPONS COMMAND	BLOCK, HANDGRIP	
TS			FRACTIONS ± ANGLES ± °	DRAFTSMAN	SPRINGFIELD 1, MASS. U.S. ARMY MATERIEL COMMAND		
EL 2				TRACER			
RA	SEE ENGINEERING RECORDS	SEE NOTE 3	MATERIAL	ENGINEER		19205 C 11010004	
BH	NEXT ASSY USED ON APPLICATION	SEE NOTE 4	HEAT TREATMENT	SUBMITTER			
RH	C44 TO 49	DO NOT APPLY PART NO	FINAL PROTECTIVE FINISH	APPROVER			
			OF MIL-STD-171			SCALE 2/1 UNIT W" SHEET 1 OF 1	

NOTES:  
1. MIL-W-13855 APPLIES.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
A	SEE ED SA 29267	20 MAY 66	US Army
B	(3) SEE ERR HQR 30617	22 JAN 73	EPS
C	NORGIS 9451/910423	910605	CHS 94 10



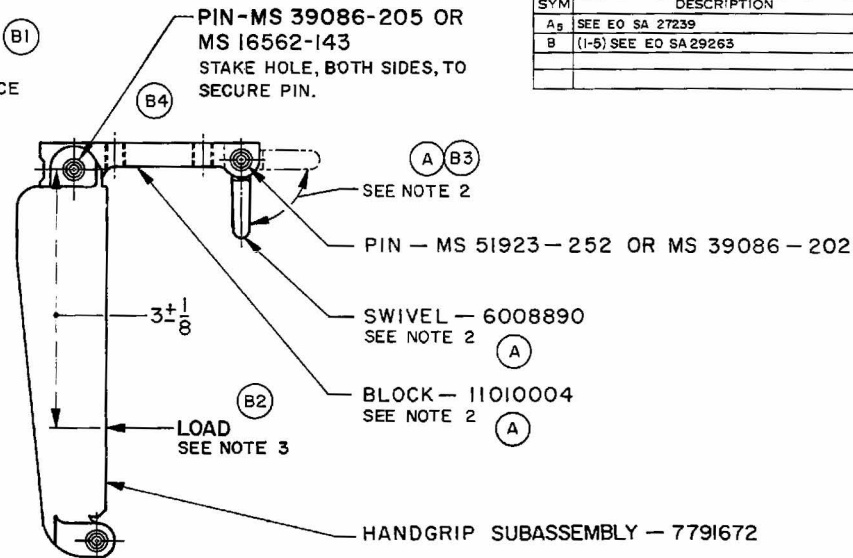
FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 11010038

PART NO. 11010038

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 23 OCT 63		SPRINGFIELD ARMORY, SPRINGFIELD, MA	
YP		TOLERANCES ON DECIMALS ±		ENGINEER	CHECKER	SLING, SMALL ARMS	
TS		FRACTIONS ±		ENGINEER	CHECKER		
EL 2		ANGLES ±		ENGINEER	CHECKER		
RA	11010108	RIFLE, M14A1		ENGINEER	CHECKER		
BH		NEXT ASSY USED ON		ENGINEER	CHECKER		
RH		APPLICATION		ENGINEER	CHECKER		
DO NOT APPLY PART NO		HEAT TREATMENT		APPROVED		CODE IDENT NO DWG S-EE	
-AS-SPECIFIED-		FINAL PROTECTIVE FINISH		19205 D		11010038	
				SCALE 1/2		UNIT WT	
				SHEET 1 OF 1			

NOTES:

1. BRIGHT SURFACE RESULTING FROM ASSEMBLY OF PINS AND STAKING SHALL BE TOUCHED UP IN ACCORDANCE WITH DWG C7792281.
2. AFTER ASSEMBLY, THE SWIVEL SHALL BE CAPABLE OF BEING ROTATED USING LIGHT FINGER PRESSURE. THE WIDTH OF THE SLOT IN BLOCK MAY BE ADJUSTED PRIOR TO ASSEMBLY TO MEET THIS REQUIREMENT. THE SWIVEL SHALL NOT SWING FREELY.
3. THE HANDGRIP SHALL WITHSTAND A MINIMUM LOAD OF 200 POUNDS AS SHOWN.



REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
A	SEE EO SA 27239	21 NOV 63	<i>R. Henry</i>
B	(1-5) SEE EO SA 29263	2 MAY 65	<i>R. Henry</i>

FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 11010044

(B5) PART NO. 11010044

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 23 OCT 63	SPRINGFIELD ARMORY U. S. ARMY WEAPONS COMMAND SPRINGFIELD 1, MASS. U. S. ARMY MATERIEL COMMAND	
YP	F11686528	RIFLE, M14E2	TOLERANCES ON DECIMALS ±	DRAFTSMAN <i>W. J. Henry</i>	CHECKER <i>W. J. Henry</i>	HANDGRIP ASSEMBLY
TS			FRACTIONS ±	TRACER <i>W. J. Henry</i>	CHECKER <i>EPS</i>	
EL 2			ANGLES ±	ENGINEER <i>W. J. Henry</i>	ENGINEER <i>W. J. Henry</i>	
RA	SEE ENGINEERING RECORDS		MATERIAL	SUBMITTED	APPROVED	
BH	NEXT ASSY	USED ON	HEAT TREATMENT	APPROVED <i>W. J. Henry</i>		CODE IDENT NO. DWG SIZE
RH	DO NOT	APPLY PART NO	FINAL PROTECTIVE FINISH			19205 B 11010044
AS SPECIFIED					SCALE 1/1 UNIT WT SHEET 1 OF 1	

SWESP 1176-1  
28 AUG 62

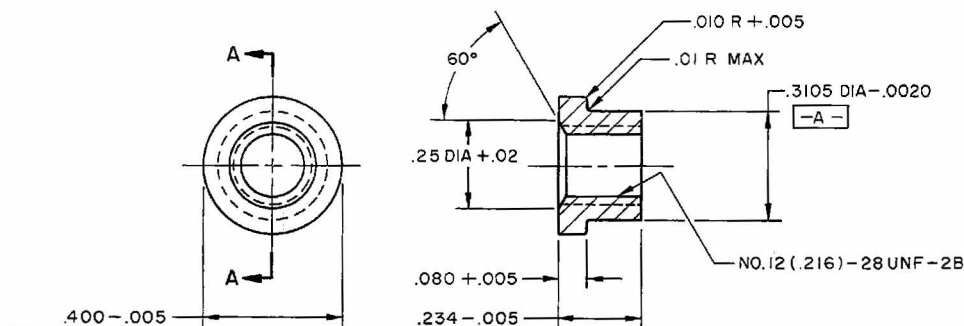
1

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REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
A	(1) SEE EO SA 29263	18 MAY 66	<i>R. J. Selt</i>

# NOTES

1. FINISH 125/.
2. ALL EDGES SHALL BE BROKEN .005 ± .010 UNLESS OTHERWISE SPECIFIED.



SECTION A-A

PART NO. 11010047

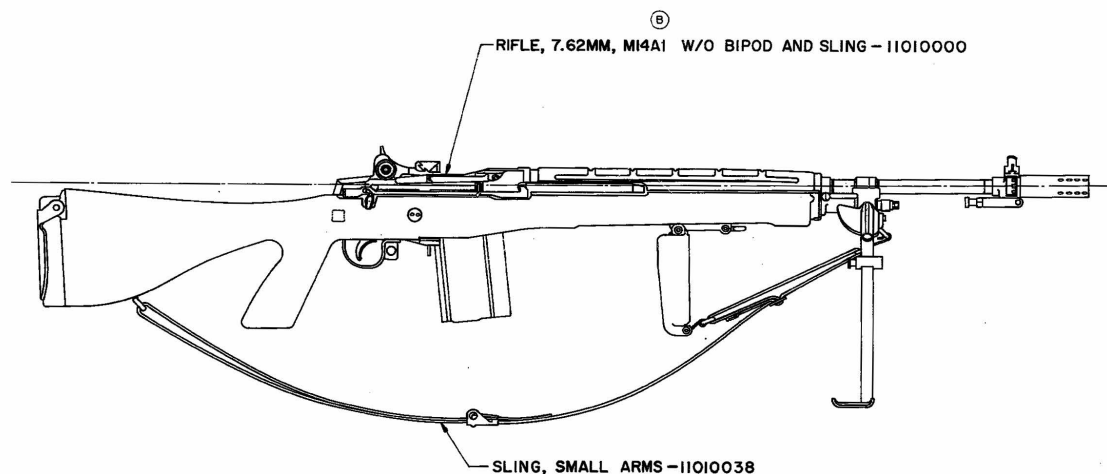
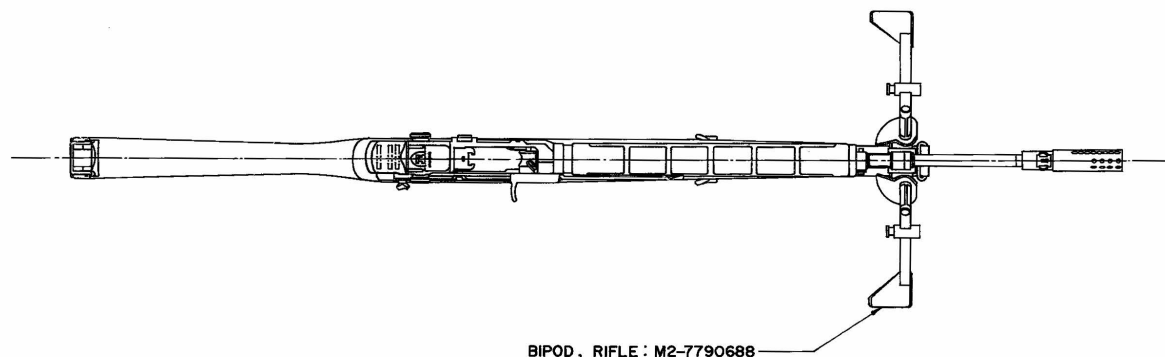
MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 23 OCT 63	SPRINGFIELD ARMORY U. S. ARMY WEAPONS COMMAND SPRINGFIELD 1. MASS. U. S. ARMY MATERIEL COMMAND
YP	F11686528 RIFLE, M14E2	TOLERANCES ON DECIMALS ±	FRACTIONS ±	DRAFTSMAN CHECKER <i>T.H.S.</i>	BUSHING, SWIVEL
TS	SEE ENGINEERING RECORDS	ANGLES ± 1°	MATERIAL: STEEL, FED. SPEC QQ-S-634:1018 THRU 1022	TRACER CHECKER <i>PH</i>	
EL 2	NEXT ASSY USED ON	HEAT TREATMENT NONE	ENGINEER <i>PH</i>	ENGINEER <i>PH</i>	
RA	APPLICATION	FINAL PROTECTIVE FINISH FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171	SUBMITTED <i>PH</i>	APPROVED <i>R. J. Selt</i>	
BH	DO NOT APPLY PART NO			CODE IDENT NO 19205	DWG SIZE B
RH	DO NOT APPLY PART NO			SCALE 4/1	UNIT W"
				SHEET 1 OF 1	

SWESP 1176-1  
28 AUG 62



REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
A	REDESIGN WITH CHANGE REEED SA 17647	30 JAN 65	<i>[Signature]</i>
B	(1-2) SEE EO HQR 92197	4 SEP 69	<i>[Signature]</i>
C	21 SEE ERR HQR 90617	22 JAN 70	<i>[Signature]</i>

- NOTES:
1. MIL-W-13855 APPLIES.
  2. FOR INFORMATION ONLY:  
SUPPORT EQUIPMENT IS LISTED ON  
DWG A12002927. SUPPORT EQUIPMENT  
IS NOT PACKAGED OR INCLUDED WITH  
THE RIFLE.



SLING, SMALL ARMS - 11010038

FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 11010108

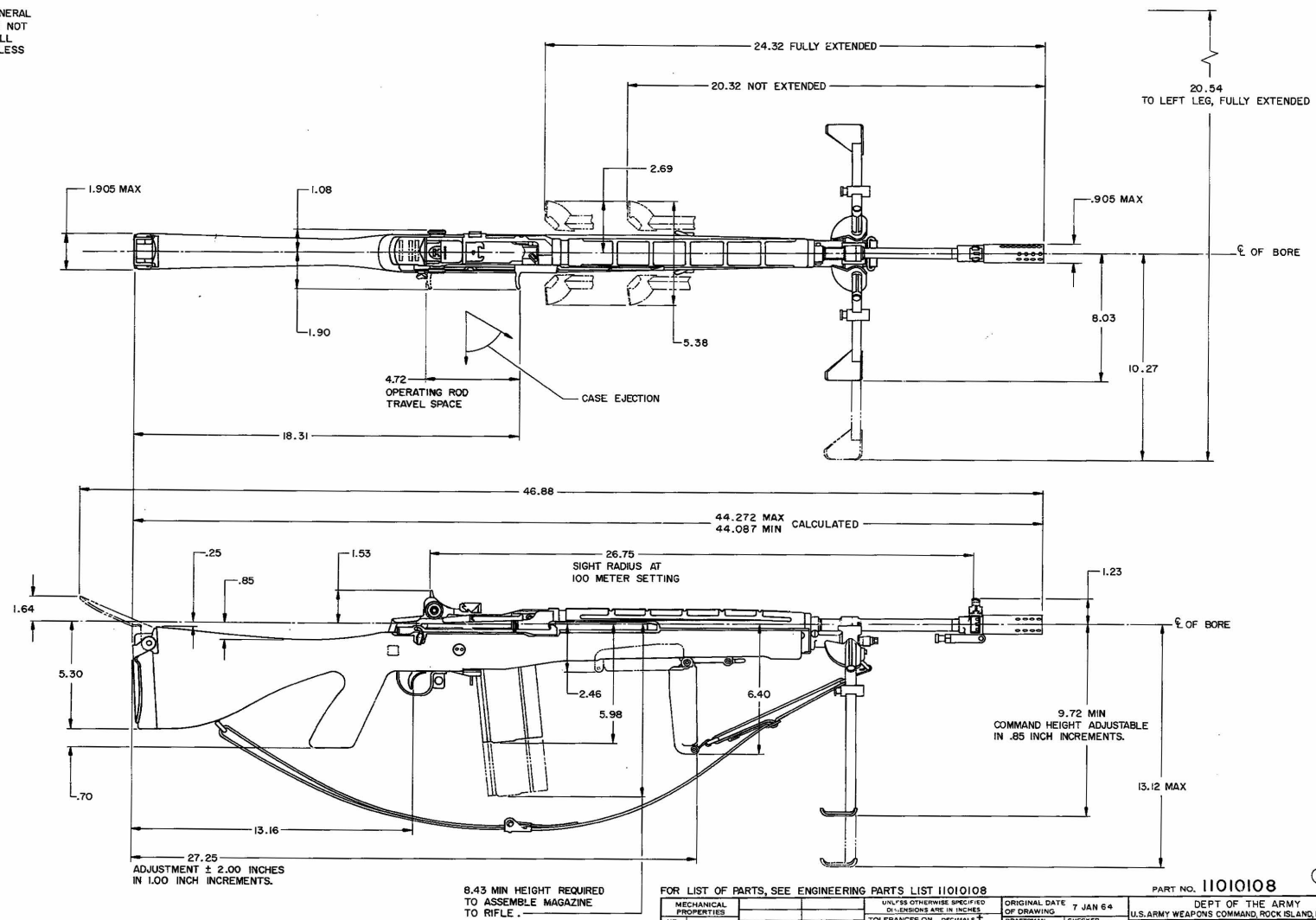
MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 7 JAN 64		PART NO. 11010108	
VP		TOLERANCES ON DECIMALS		DESIGNER	CHECKER	DEPT OF THE ARMY	
TS		FRACTIONS	ANGLES	<i>[Signature]</i>	<i>[Signature]</i>	U.S. ARMY WEAPONS COMMAND, ROCK ISLAND, ILL. 61201	
SL 2		MATERIAL		ENGINEER	CHECKER	RIFLE, 7.62MM, M14A1	
RA		HEAT TREATMENT		<i>[Signature]</i>	<i>[Signature]</i>	CODE IDENT NO. DWG SIZE	
BH		APPLICATION		SUBMIT TO		19204 F 11010108	
RH		DO NOT APPLY PART NO.		APPROVED		SCALE 1/2 UNIT WT SHEET 1 OF 2	
		NO SPECIFIED		<i>[Signature]</i>			



(C)

NOTES:  
1. THIS SHEET IS INTENDED FOR GENERAL REFERENCE PURPOSES ONLY AND IS NOT TO BE USED FOR MANUFACTURE. ALL DIMENSIONS ARE APPROXIMATE UNLESS OTHERWISE SPECIFIED.

REVISIONS			
S-N	DESCRIPTION	DATE	APPROVAL
A	REDRAWN WITH CHANGE SEE ED 54 27547	20 JAN 40	W. H. H. H.
B	(1) SEE ED HRO 52197	1 SEP 69	W. H. H. H.
C	(2) SEE ED HRO 50677	22 JAN 75	W. H. H. H.



FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 11010108

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
YP		TOLERANCES ON DECIMALS	
TS		FRACTIONS	
EL 2		ANGLES	
RA		MATERIAL	
BH	NEXT ASSY USED ON	HEAT TREATMENT	
RH	APPLICATION	FINAL PROTECTIVE FINISH	
DO NOT	APPLY PART NO		
AS SPECIFIED			

ORIGINAL DATE OF DRAWING	7 JAN 64
DRAWN BY	W. H. H. H.
CHECKED BY	W. H. H. H.
DESIGNED BY	W. H. H. H.
SUBMITTED BY	W. H. H. H.
APPROVED BY	W. H. H. H.

PART NO. 11010108	
DEPT OF THE ARMY	
U.S. ARMY WEAPONS COMMAND, ROCK ISLAND, ILL. 61201	
RIFLE, 7.62MM, M14A1	
CODE IDENT NO. LOW SIZE	19204 F
SCALE 1/2	UNIT WT
SHEET 2 OF 2	

MECHANICAL PROPERTIES		DO NOT	APPLY PART NO.	REVISIONS			
		DO	AS SPECIFIED	SYM	DESCRIPTION	DATE	APPROVAL
YP			APPLICATION	A	(1) SEE EO HRD 920782	25 JUN 69	<i>[Signature]</i>
TS			NO. 1. AREA	B	SEE EO HRD 02138	7 FEB 75	<i>[Signature]</i>
EL2			USED ON	C	(3) SEE ERR HQR 40681	10 FEB 75	<i>[Signature]</i>
RA			F 11010263	D	NOR W4S2051/840824	86C121	MR
BH			RIFLE.M14		(ECP W9S2014/790608)		<i>[Signature]</i>
RH					(ECP W5S2069/851223)		

NOTES:

1. SAME AS MS 16535-307, <sup>(1)</sup> ALTER AS SHOWN.

2. <sup>(1)</sup> FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.

3. MIL-W-13855 SHALL APPLY.

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

ORIGINAL FSCM NO. 19205

ALTERED ITEM DRAWING

PART NO. 11010260

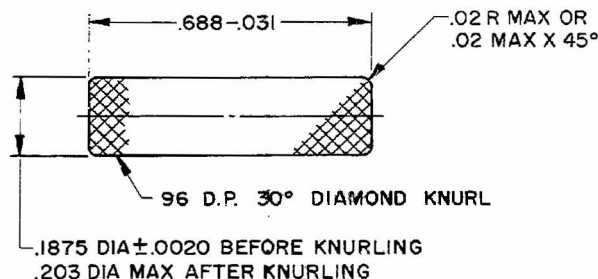
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	ORIGINAL DATE OF DRAWING 25 JUN 64	DEPT OF THE ARMY ROCK ISLAND ARSENAL ROCK ISLAND, ILL. 61201	
TOLERANCES ON FRACTIONS DECIMALS ANGLES	DRAFTSMAN CHECKER		
MATERIAL	TRACER CHECKER	RIVET, TUBULAR OVAL HEAD	
HEAT TREATMENT	APPROVED SUBMITTED	CODE IDENT NO.	DWG SIZE
FINAL PROTECTIVE FINISH SEE NOTE 2		19204	A 11010260
		SCALE	UNIT WT SHEET   OF

SWESP 1181-1  
28 AUG 62

MECHANICAL PROPERTIES		APPLY PART NO.		REVISIONS			
YP		APPLICATION		LTR	DESCRIPTION	DATE	APPROVED
TS		NEXT ASSY	USED ON	A	(1) SEE EO SA 28757	17 DEC 65	<i>[Signature]</i>
EL2		SEE ENGINEERING RECORDS		B	(1-2) SEE EO 82048	11 MAR 68	<i>[Signature]</i>
RA		F11686426	RIFLE, M14	C	NOR W8S2022/79-03-26	79-04-01	<i>[Signature]</i>
BH				D	NOR WIS0034/810915	860811	MR
RH							

NOTES:

1. MATERIAL: ALUMINUM, FED. SPEC QQ-A-225/6  
OR FED. SPEC QQ-A-225/8



FSCM NO. <b>19200</b>		US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801		PART NO. <b>11010261</b>	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING <b>16 JUL 65</b>		DEPT OF THE ARMY <del>ROCK ISLAND ARSENAL</del> <del>ROCK ISLAND, ILL 61201</del>	
TOLERANCES ON FRACTIONS DECIMALS ANGLES		DRAFTSMAN <i>[Signature]</i> CHECKER <i>[Signature]</i> TRACER <i>[Signature]</i> CHECKER <i>[Signature]</i> ENG. <i>[Signature]</i>		PIN, STRAIGHT, KNURLED	
MATERIAL <b>SEE NOTE 1</b>		SUBMITTED <i>[Signature]</i>		DWG SIZE <b>A</b> CODE IDENT NO. <b>19204</b> <b>11010261</b>	
HEAT TREATMENT		APPROVED <i>[Signature]</i>		SCALE <b>4/1</b> UNIT WT SHEET <b>1</b> OF <b>1</b>	
FINAL PROTECTIVE FINISH					

SWESP FORM NO. 1181-1  
20 MAR 64 REV.

↑ REF SAA - 27962

PDC

MECHANICAL PROPERTIES		APPLY PART NO.		REVISIONS			
YP		APPLICATION		LTR	DESCRIPTION	DATE	APPROVED
TS		NEXT ASSY	USED ON	A	(1) SEE EO 82000	5 FEB 68	<i>P. Delaney</i>
EL2				B	(1) SEE EO HRD 92078-2	25 JUN 69	<i>K. H. J.</i>
RA				C	SEE EO HRD 02138	71 FEB 25	<i>K. H. J.</i>
BH		F7267000	RIFLE, M14	D	(2) SEE ERR HQR 40681	10 FEB 75	<i>W. J. J.</i>
RH		F7790600	LAUNCHER	E	NOR W832022/79-03-26	79-04-01	<i>S. A. R. H. J.</i>
			M79				
		F11010000	RIFLE, M14A1	F	NORW4S2051/840824	860121	<i>K. H. J.</i>
		J9386974	RIFLE, M14NM	G	ECPW5S2069 /851223		<i>S. A. R. H. J.</i>
					ERR Z9Z2118M	891213	<i>S. A. R. H. J.</i>
					(ECP W9S2019/790629)		<i>S. A. R. H. J.</i>

(B) (C) (D)

NOTES:

1. SAME AS MSI6998-II,  $\Delta$  ALTER AS SHOWN.
2.  $\Delta$  FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.
3. MIL-W-13855 SHALL APPLY.

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

ALTERED ITEM DRAWING

SIGHT - 7791122  
USED WITH : SIGHT - 7791568  
SIGHT - 7791445

PART NO. 11010298

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	ORIGINAL DATE OF DRAWING 17 NOV 64	SPRINGFIELD ARMORY, SPRINGFIELD, MA	
TOLERANCES ON FRACTIONS DECIMALS ANGLES	DRAFTSMAN <i>W. H. S.</i> CHECKER <i>EPS</i>	SCREW, CAP, SOCKET HEAD, HEXAGON	
	TRACER <i>W. H. S.</i> CHECKER <i>R. S. W.</i>		
MATERIAL	ENGR <i>R. F. H.</i> ENGR <i>W. H. S.</i>	DWG SIZE CODE IDENT NO.	
HEAT TREATMENT	SUBMITTED	A 19205 11010298	
FINAL PROTECTIVE FINISH SEE NOTE 2	APPROVED <i>W. A. L. H. J.</i>	SCALE —	UNIT WT SHEET 1 OF 1

SWESP FORM NO. 1181-1  
20 MAR 64 REV.

↑ SCANNED DUPLICATE ORIGINAL

MECHANICAL PROPERTIES		APPLY PART NO.		REVISIONS			
YP		APPLICATION		LTR	DESCRIPTION	DATE	APPROVED
TS		NEXT ASSY	USED ON	A	SEE EO 82048	11 MAR 68	<i>P. H. H.</i>
EL2				B	(1) SEE EO HRD 92078-2	25 JUN 69	<i>P. H. H.</i>
RA		C11010362	RIFLE, M14	C	SEE EO HRD 02138	71 FEB 75	<i>P. H. H.</i>
BH			.30R MI,	D	(2) SEE ERR HQR 40681	30 FEB 75	<i>P. H. H.</i>
RH			MIC 8 MID	E	NOR W8S2022/79-03-26	79-04-01	<i>SAC P. H. H.</i>
			RIFLE, M4	F	NOR W4S2051/840824	860121	<i>P. H. H.</i>
					ECPW5S2069 /851223		

NOTES:

1. SAME AS MS35335-31,  $\Delta$  ALTER AS SHOWN.
2.  $\Delta$  INSIDE DIAMETER: .169 + .007
3.  $\Delta$  FINISH: PLAIN

ORIGINAL FSCM NO. 19205

ALTERED ITEM DRAWING

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

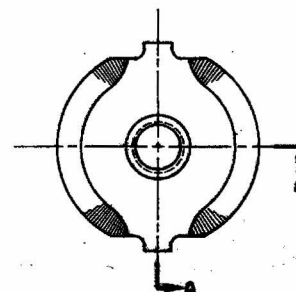
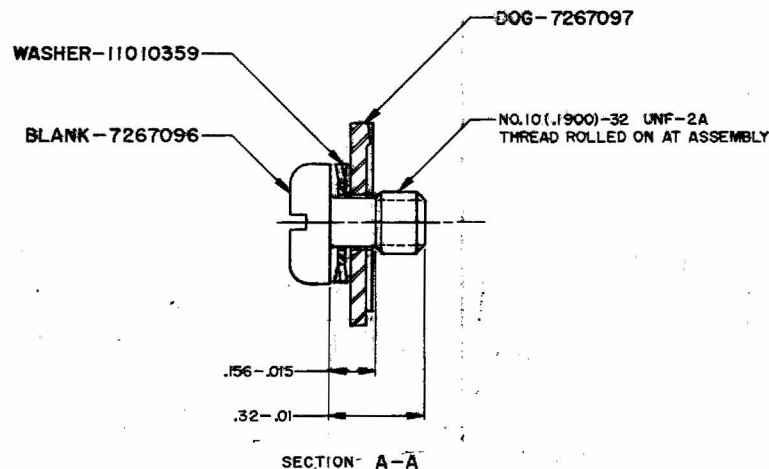
PART NO. 11010359

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 7 SEP 65		DESIGN OF THE ARMY ROCK ISLAND, ILL. 61201	
TOLERANCES ON FUNCTIONS DECIMALS ANGLES		DRAFTSMAN <i>W. H. S.</i> CHECKER <i>DSA</i>		WASHER, LOCK	
+		TRACER <i>W. H. S.</i> CHECKER <i>W. H. S.</i>		DWG SIZE	
-		ENGINEER <i>W. H. S.</i>		19204	
MATERIAL		SUBMITTED		11010359	
HEAT TREATMENT		<i>P. H. H.</i>		A	
FINISH PROTECTIVE FINISH		APPROVED <i>P. H. H.</i>		SCALE	
AT ASSEMBLY				UNIT WT	
				SHEET   OF	

SWESP FORM NO. 1181-1  
20 MAR 64 REV.

NOTES:

1. DOG SHALL NOT DISENGAGE FROM BLANK AFTER THREADS ARE ROLLED.
2. MIL-W-13855 SHALL APPLY.



ORIGINAL FSCM NO.19205

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 11010362

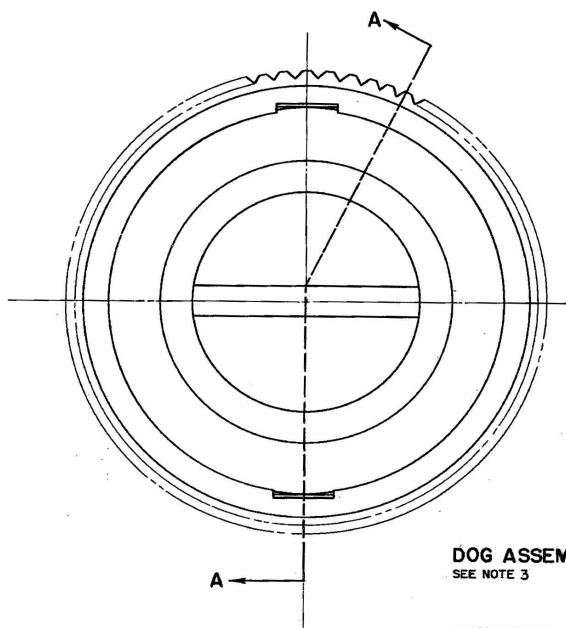
PART NO. 11010362

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 7 SEP 65		PART NO. 11010362	
YP		DT1010363	RIFLE, M14	DRAFTSMAN	WHS	CHECKER	DSK
TS		A11010364	.30R-M1, NYC	TRACER	WHS	CHECKER	NSA
EL 2			BWID	ENGINEER	WHS	CHECKER	NSA
RA				SUBMITTED			
BH							
RH							
APPLICATION		HEAT TREATMENT		APPROVED		DWG SIZE CODE IDENT NO.	
				R. A. Cole		C 1020 11010362	
		FINAL PROTECTIVE FINISH		R. A. Henry		SCALE 4/1 1 UNIT WT	
		FINISH 5.3.1.2 OR 5.3.22 OF MIL-STD-171				SHEET 1 OF 1	

REVISONS			
SYM	DESCRIPTION	DATE	APPROVAL
	REPLACES WITH CHANGE DW. 07267039, REV C. SEE EO SA 27806		
A	(1)-23SEE EO 82048	11MAR 68	<i>P. H. ...</i>
B	(1) SEE EO HRD 92078-2	25 JUN 69	<i>P. H. ...</i>
C	SEE EO HRD 02128	71 FEB 65	<i>P. H. ...</i>
D	NOR WBS 2022/79-03-26	79-04-01	<i>SA [Signature]</i>
E	NORWAS2051/84 08 24		
F	ECPNW552069R1/ 9110 23	8601 21	<i>[Signature]</i>
G	NOR G15149 9 15 123	5112 03	<i>[Signature]</i>

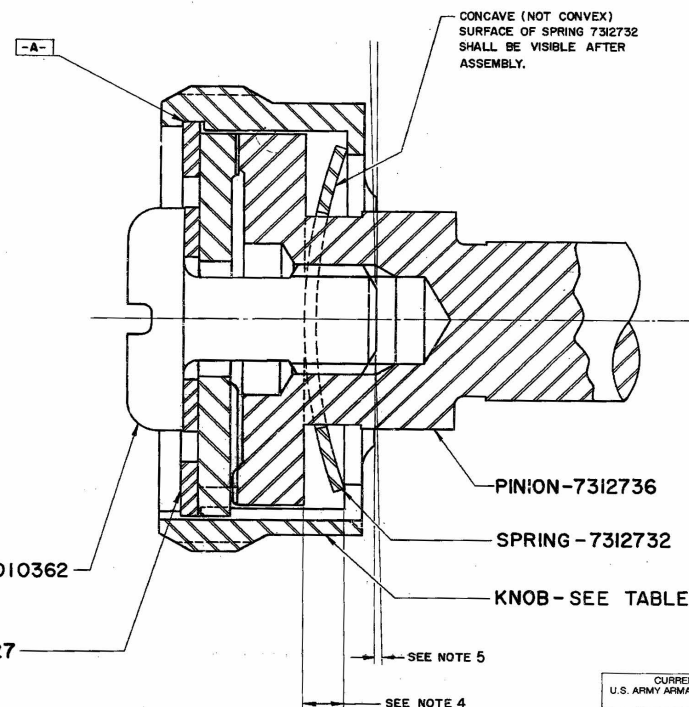
## NOTES

1. LOCATION OF MANUFACTURERS IDENTIFICATION MARK FOR THESE ASSEMBLIES SHOWN ON KNOB DWGS D7267039 AND D7312734.
2. RETAINER 7312727 SHALL BE COMPRESSED FLAT AND TIGHT INTO GROOVE BY THE APPLICATION OF STEADY PRESSURE IN SUCH A MANNER THAT THE SPRING 7312732 SHALL NOT BE COMPRESSED FLAT OR SOLID IN THE PROCESS. AFTER INSTALLATION THE RETAINER SHALL REMAIN FLAT AND TIGHT IN THE GROOVE WITH THE FLAT ENGAGING THE SHOULDER, SHOWN AT -A- CONCENTRICALLY TO PREVENT THE RETAINER FROM LOOSENING AND DISASSEMBLING.
3. AFTER ASSEMBLY, SCREW MUST BE BACKED OFF 2 1/4 TURNS FROM A SEATED POSITION BEFORE DISENGAGING. AFTER DISENGAGEMENT, EACH TURN OF THE SCREW SHOULD RESULT IN AN AUDIBLE CLICK. DO NOT TRY TO REMOVE THE SCREW FROM THE ASSEMBLY, AS IT IS LOCKED INTO PLACE TO PREVENT ITS LOSS OR REMOVAL.
4. SPRING TEST: THE PINION SHALL BE CAPABLE OF AT LEAST .040 FREE LONGITUDINAL MOVEMENT UNDER SPRING TENSION WITHIN THE KNOB, WITHOUT RESTRICTION BY THE KNOB.
5. KNOB TEST: THE KNOB SHALL BE CAPABLE OF TIPPING AWAY FROM A NORMAL POSITION IN ANY DIRECTION WITHOUT BINDING ON THE PINION, AN AMPLITUDE AMOUNT TO PERMIT ENGAGEMENT OF THE INDEXING TOOTH TO FULL WORKING DEPTH IN THE SERRATIONS OF THE RECEIVER OR EQUIVALENT GAGE MINIMUM OF 1° 30'
6. MIL-W-13855 SHALL APPLY.



DOG ASSEMBLY-11010362  
SEE NOTE 3

RETAINER - 7312727  
SEE NOTE 2



SECTION A-A

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

APPLICATION	KNOB USED	PINION ASSY
RIFLE, 7.62MM M14, M14A1, M14-NM	7267098	11010363
U.S. RIFLE, CAL .30, M1, MIC, MID, M1-NM	7312734	11010364

AI ORIGINAL FSCM NO.19205

SPRINGFIELD ARMORY, SPRINGFIELD, MA

PINION ASSEMBLY,  
REAR SIGHT ELEVATING

CODE IDENT NO.	DWG SIZE	
19205	D	11010363

SCALE 10/1	UNIT WT	SHEET 1 OF
------------	---------	------------

DISTRIBUTION STATEMENT A. APPROVED FOR PUBLIC RELEASE;  
DISTRIBUTION IS UNLIMITED.

J33859374 - <u>W/FILE</u> <u>MM/M</u> 7260598 SOR - <u>W</u> 7260599 SOR - <u>WIC</u> 7268700 SOR - <u>MD</u> 7267000 RIFLE, <u>M14</u>		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES $\pm$ DECIMALS $\pm$ FRACTIONS $\pm$ ANGLES $\pm$ MATERIAL	ORIGINAL DATE OF DRAWING 7 SEP 65 DRAFTSMAN <u>WHS</u> CHECKER <u>DSK</u> TRACER <u>WHS</u> CHECKER <u>DSK</u> ENGINEER <u>J.S. Cole</u> ENGINEER <u>J.S. Cole</u> SUBMITTED <u>J.S. Cole</u>	(A1) ORIGINAL FSCM NO.19205 SPRINGFIELD ARMOY, SPRINGFIELD, MA PINION ASSEMBLY, REAR SIGHT ELEVATING
MECHANICAL PROPERTIES YP TS EL. 2 RA BH	NEXT ASSY. USED ON APPLICATION	HEAT TREATMENT	COORDINATE DRAWING SIZE 19205 D 11010363 SCALE 10/1 UNIT WT SHEET 1 OF 1	
RM DESIGNED DO	APPLY PART NO SEE NOTE 2 AS SPECIFIED	FINAL PROTECTIVE FINISH	APPROVED <u>K.S. Henry</u>	





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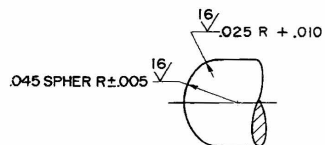
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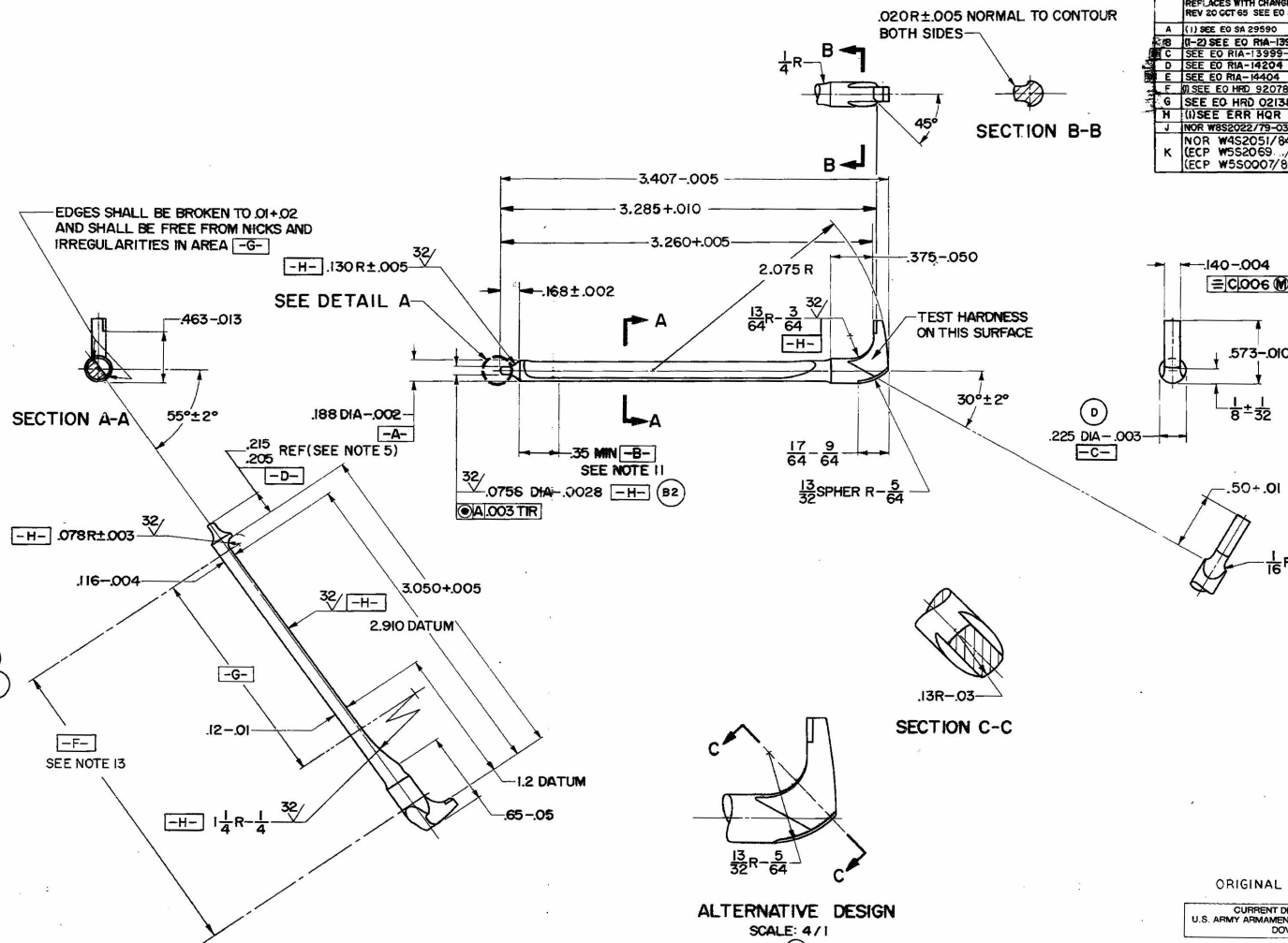
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## NOTES:

1. FINISH  $\sqrt{63}$  EXCEPT AS NOTED.
2. ALL EDGES SHALL BE BROKEN .005+.010 UNLESS OTHERWISE SPECIFIED.
3. STEEL, **COMPEN 8640** OR 8645 OR 8740 SPHEROIDIZED, SPEC ASTM A304, A322, A331; AUSTENITE GRAIN SIZE 7 OR FINER.
4. HEAT TREATMENT: BEFORE CHROMIUM PLATING HEAT AT 1500°F TO 1550°F. OIL QUENCH. TEMPER 1 HOUR AT HEAT TO HARDNESS SPECIFIED. NO DECARBURIZATION PERMISSIBLE.
5. AREA **-D-** SHALL BE BUFFED BEFORE AND AFTER CHROMIUM PLATING.
6. FIRING PIN SHALL BE FREE FROM BURRS, PITS, ETC. PRIOR TO CHROMIUM PLATING.
7. STRAIGHTENING AFTER CHROMIUM PLATING IS NOT PERMISSIBLE.
8. AFTER CHROMIUM PLATING, FIRING PIN SHALL BE BAKED AT 375°F FOR 3 HRS MIN.
9. DIMENSIONS APPLY AFTER CHROMIUM PLATING.
10. DIA **-A-** FOR LENGTH **-B-** AND DIA **-C-** TO BE ON A COMMON CENTER. THE SECTION BETWEEN SHALL NOT BE MORE THAN .003 ECCENTRIC (.006 TIR)
11. REMOVE LATERAL & CIRCUMFERENTIAL LINES FROM SURFACES **-H-** BEFORE CHROMIUM PLATING.
12. CHROMIUM PLATING DISCOLORATION OR LACK OF CHROMIUM PLATING RESULTING FROM ELECTRODE CONTACT, NOT TO EXCEED .125 MAX LENGTH IS PERMISSIBLE IN AREA **-F-**.
13. THICKNESS OF CHROMIUM PLATING SHALL BE .0002 TO .0004 ON BODY, BUT MAY BE .0002 TO .0008 ON .168 TIP LENGTH (DETAIL A), AND END AREA WITHIN 17/64 LENGTH.
14. MIL-W-13865 SHALL APPLY.



DETAIL A  
SCALE: 20/1



ALTERNATIVE DESIGN  
SCALE: 4/1

REVISIONS			
LTR	DESCRIPTION	DATE	APPROVED
	REPLACES WITH CHANGE DWG 0778417 REV 20 OCT 65 SEE EO SA28550		
A	(1) SEE EO SA 29580	23 AUG 66	
B	(1-2) SEE EO RIA-13999	2-16-67	
C	SEE EO RIA-13999-1	4-6-67	
D	SEE EO RIA-14204	4-26-67	
E	SEE EO RIA-14404	9-18-67	
F	SEE EO HRD 92078-2	25 JUN 69	
G	SEE EO HRD 02138	17 FEB 75	
H	(1) SEE ERR HQR 40681	10 FEB 75	
J	NOR W852022/79-03-26	79-04-01	SA/121
K	NOR W452051/840824 (ECP W552069 /851223) (ECP W550007/850410)	860121	86

ORIGINAL FSCM NO. 19205

CURRENT DESIGN ACTIVITY FSCM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

PART NO. 11686413

STATE OF THE ART  
ROCK ISLAND ARSENAL - ROCK ISLAND, ILL 61220

PIN, FIRING

DWG SIZE 1000-1000-1000

D 11686413

SCALE 2/1 UNIT WT SHEET 1 OF 1

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING	
YP	C7790187	RIFLE, M14	TOLERANCES ON DECIMALS ± .01 FRACTIONS ± 1/64 ANGLES ± 1°	20 OCT 65	
TS		RIFLE, M14 AI			
EL 2		RIFLE, M14 AI			
RA		RIFLE, M14 AI			
BH					
RH	C43 TO 48				
NEXT ASSY USED ON		HEAT TREATMENT		SUBMITTED	
APPLICATION		SEE NOTE 4		APPROVED	
APPROVED		FINAL PROTECTIVE FINISH		APPROVED	
		FINISH 1.2.2 OF MIL-STD-171			

DRAWING SIZE F

## NOTES:

1. UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS SHALL BE BROKEN .015+.015.

## 2. MATERIAL:

A. PLASTIC (PREMIX MOULDING COMPOUND) MIL-P-43043 COLOR: FED STD NO. 595 BROWN 30025.  
B. 16 STRANDS OF PREIMPREGNATED CONTINUOUS ROVING "K" FILAMENT (50 END EQUIVALENT) WITH INSOLUBLE SILANE SIZING SHALL BE PLACED BETWEEN DIMENSIONS DEFINED BY EACH WITHIN EACH MOLDED SHELL. DISTRIBUTION OF MOLDED STRANDS SHALL RESULT IN A DOWNWARD FILAMENT SPREAD FROM TOP SURFACE.

C. ADHESIVE MIL-A-52194.  
D. PLASTIC MATERIAL (FOAM IN PLACE), MIL-P-21929, CLASS 2.

3. FINAL PROTECTIVE FINISH: EXCEPT INTERNAL AREA DEFINED BY [C].

A. PRIMER MIL-P-23377, TYPE II TWO COATS, COLOR: FED STD NO. 595, 30025, DARK GREEN.

B. TOP COAT: MIL-C-83295, COLOR: FED STD NO. 595, 30040 BROWN.

4. SHELLS LH AND RH PINS AND PLATE SHALL BE PERMANENTLY ASSEMBLED BY BONDING WITH ADHESIVE (SEE NOTE 2). ADHESIVE SHALL BE APPLIED TO ALL JOINT SURFACES, REINFORCING PIN HOLES AND PLATE CAVITIES.

5. DATUM [C] IS ESTABLISHED BY CENTRELINE OF [C] (SH 3, ZONE C4) AND [C] (SH 1, ZONE C3).

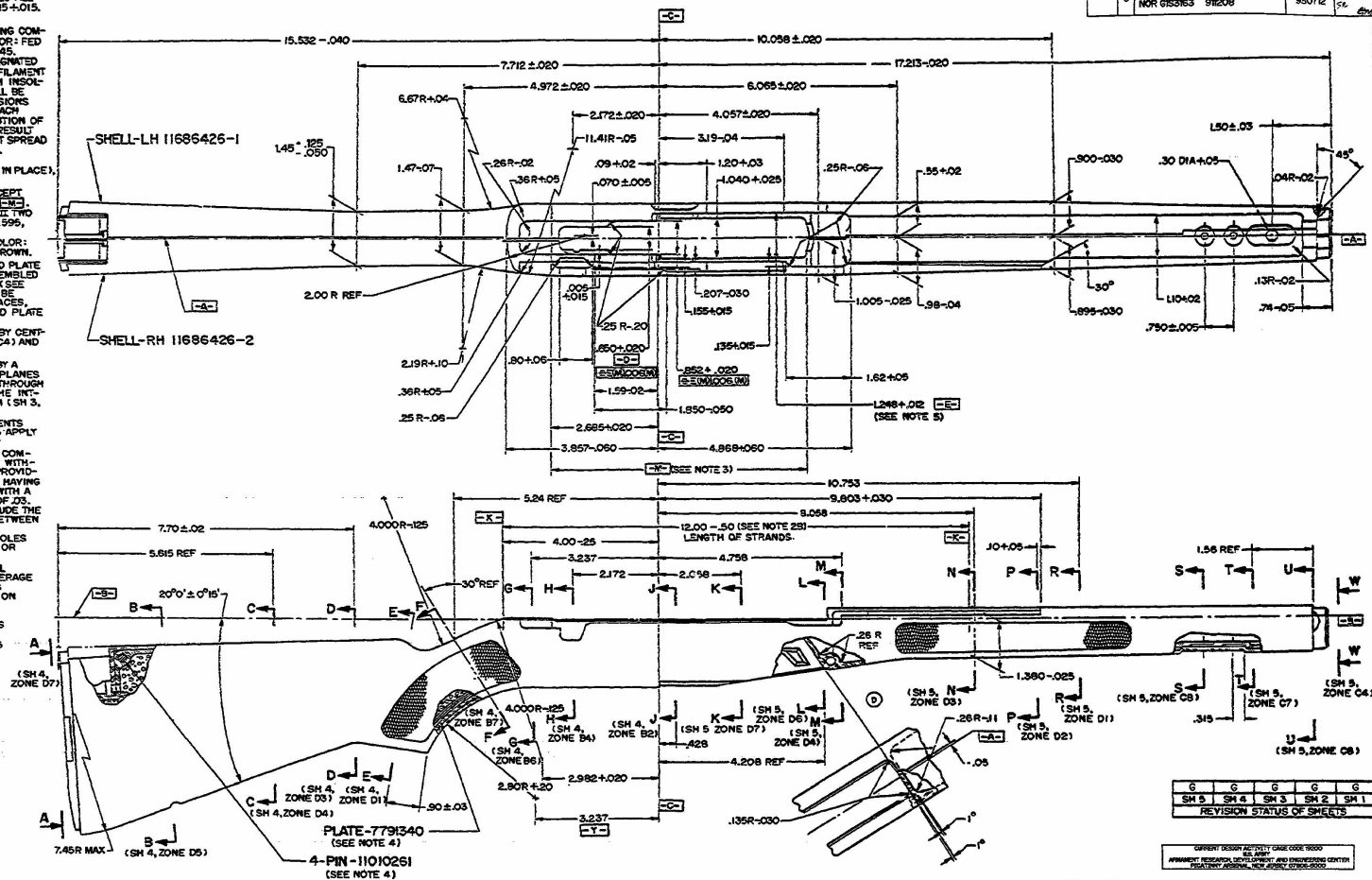
6. DATUM [C] IS ESTABLISHED BY A PLANE AT RIGHT ANGLES TO PLANES [C] AND [C] AND PASSING THROUGH THE 3" BASIC SURFACE AT THE INTERSECTIONS OF .8955 DATUM (SH 3, ZONE D4).

7. DIMENSIONS AND REQUIREMENTS SHOWN ON SHEETS 1 THRU 5 APPLY TO COMPLETED STOCK.

8. THE BUTT CAVITY SHALL BE COMPLETELY FILLED WITH FOAM WITHIN LIMITS OF [C] AND BE PROVIDED WITH ACCESSORY HOLES HAVING A HARD, SMOOTH SURFACE WITH A MINIMUM SKIN THICKNESS OF .025. THIS THICKNESS SHALL INCLUDE THE ENTIRE DENSITY GRADIENT BETWEEN MASS AND HARD SURFACE.

9. HARDNESS: HARDNESS SHALL BE MEASURED TO MINIMUM AVERAGE OF SIX READINGS. HARDNESS READINGS SHALL BE TAKEN ON RIGHT AND LEFT HAND STOCK SHELLS PRIOR TO ASSEMBLY WITHIN 24 HOURS AFTER MOLDING.

10. MIL-W-13855 AND ANSI Y14.5 APPLY.



ZONE	REV	DESCRIPTION	DATE	BY	CHK
6		REDRAWN WITH CHANGE NOR 05363 91208	930712	SL	

REV	DATE	DESCRIPTION
1		REVISED
2		REVISED
3		REVISED
4		REVISED
5		REVISED

DESIGNER: [blank]  
CHECKER: [blank]  
APPROVED: [blank]  
DATE: [blank]

FOR LIST OF PARTS SEE ENGINEERING PARTS LIST 11686426

PART NO. 11686426

PERC MECHANICAL PROPERTIES 11686426 RIFLE, MIS NEXT ASSY USED ON APPLICATION		DO NOT SCALE DRAWING PAPER ONE-SIDE SPECIFIED DIMENSIONS IN INCHES 3/16" ± .010 ANGLES: 1° THIRD ANGLE PROJECTION DATE: 17 DEC 93 BY: [blank] CHECKED: [blank] APPROVED: R. S. HENRY V.A. LUUKKONEN		SPRINGFIELD ARMOY, SPRINGFIELD, MA STOCK GUN SHOULDER (PREMIX) 11686426 F 19205 1/1	
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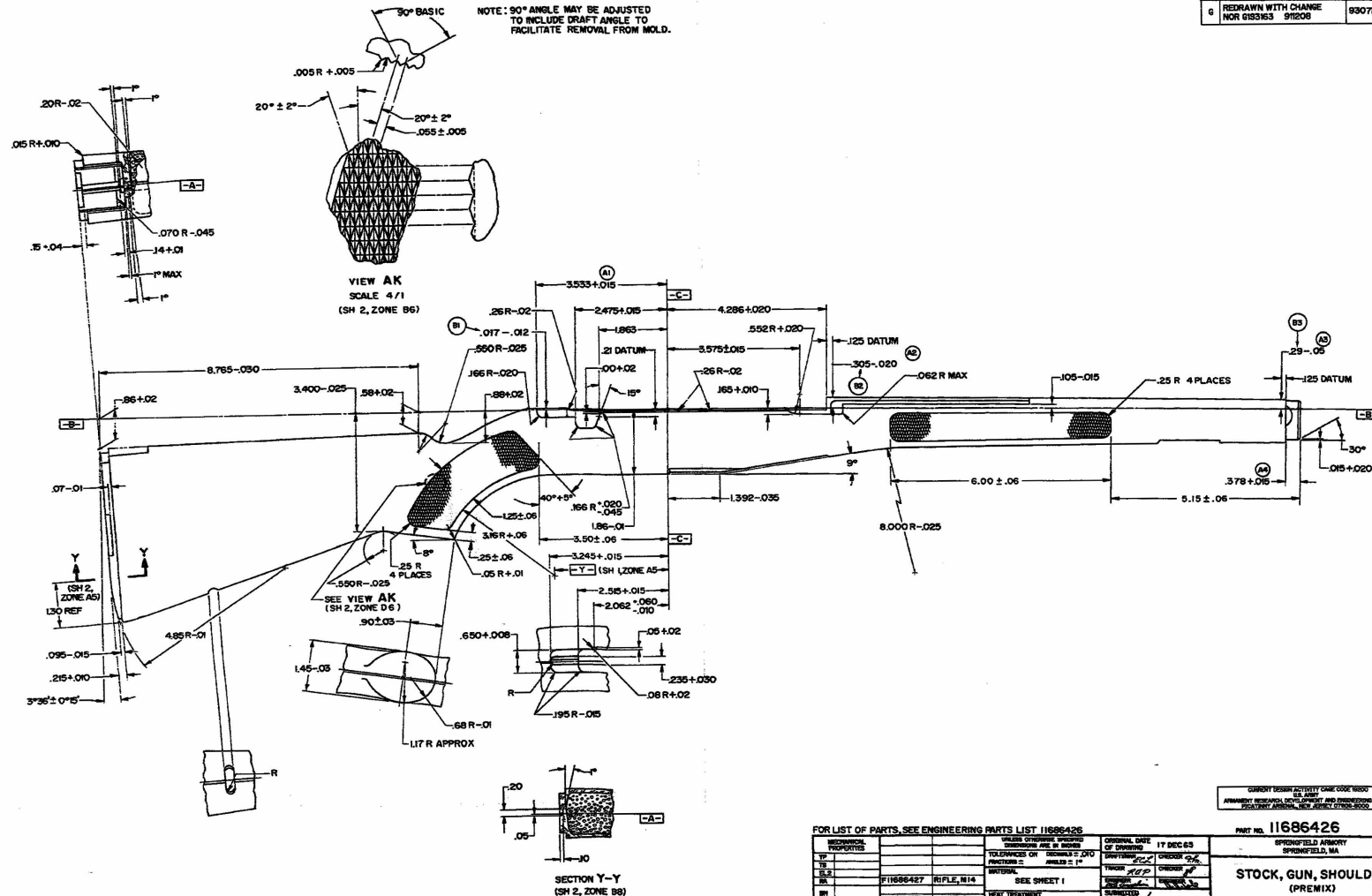
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REVISIONS			
LR	DESCRIPTION	DATE	BY
6	REDRAWN WITH CHANGE FOR BUSINESS SPECOS	930712	RLV

NOTE: 90° ANGLE MAY BE ADJUSTED TO INCLUDE DRAFT ANGLE TO FACILITATE REMOVAL FROM MOLD.



FOR LIST OF PARTS SEE ENGINEERING PARTS LIST 11686426

MECHANICAL PROPERTIES		VALUES OTHER THAN SHOWN OR INDICATED ARE IN INCHES		ORIGINAL DATE OF DRAWING	
W		TOLERANCES ON DIMENSIONS	DECIMALS ± .010	DATE	CHECKER
TS		FINISHES	AS SHOWN		
CS		FINISHES	AS SHOWN		
SA		FINISHES	AS SHOWN		
SH		FINISHES	AS SHOWN		
SH		FINISHES	AS SHOWN		
SH		FINISHES	AS SHOWN		

CHARTERED MEMBER SOCIETY CASE CODE 11686426  
ARMAMENT RESEARCH, DEVELOPMENT AND DESIGN CENTER  
FACILITY ADDRESS: NEW JERSEY 07000-0000

PART NO. 11686426

SPRINGFIELD ARMOY  
SPRINGFIELD, MA

STOCK, GUN, SHOULDER  
(PREMIX)

DATE SIZE CASE CODE  
F 19205 11686426  
SCALE 1/1 1/16" = 1"

Sheet 2 of 5

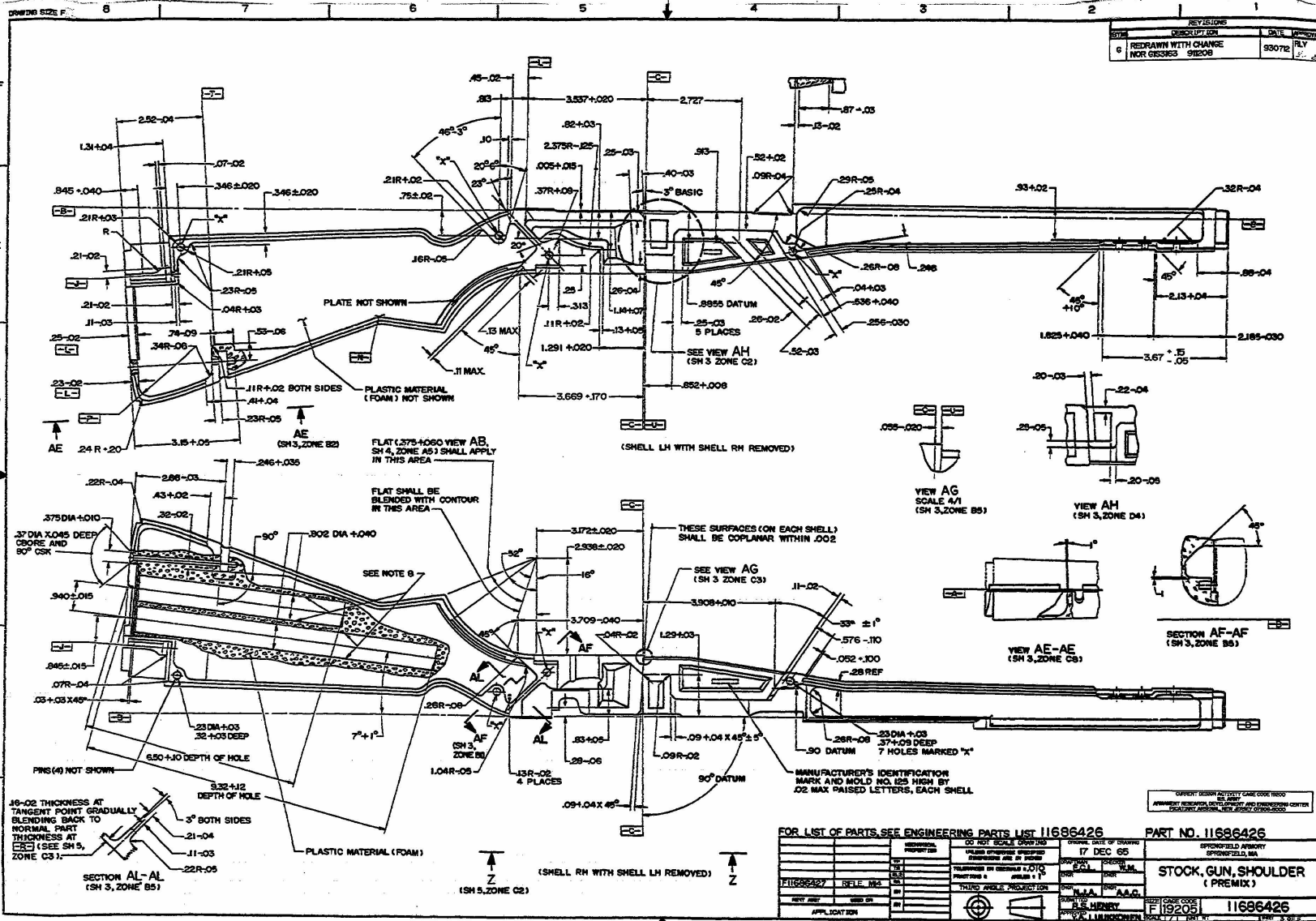
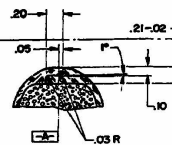


Diagram of Section B-B (SM 1, Zone B7) showing a cross-section of a structure with various dimensions and labels:

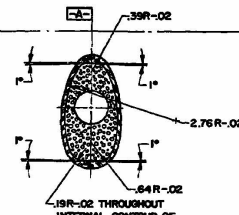
- Top dimension: .43+.02
- Top right dimension: 2"
- Left side dimension: .099-.024 FROM BUTT END TO [P] (SEE SM 3)
- Right side dimension: .09-.03
- Right side dimension: .36 R-.02 FROM [P] (SEE SM 3)
- Left side dimension: .5"
- Right side dimension: .07R-.02
- Bottom right dimension: .526+.020
- Bottom right dimension: .005
- Bottom left dimension: .761+.052
- Bottom dimension: 35"±5"

SECTION B-B  
(SM 1, ZONE B7)

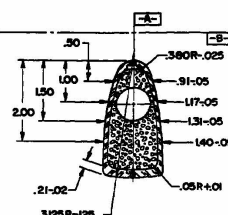
SECTION B-B  
(SH 1, ZONE B7)



PARTIAL SECTION C-C  
SCALE 2/1  
(SH 1, ZONE B6)

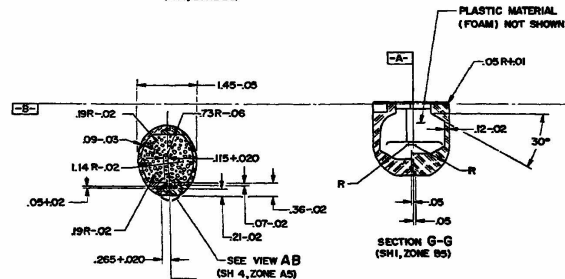


SECTION D-D  
(SH 1, ZONE B6)

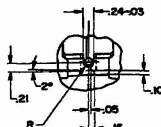


SECTION E-E  
(SH I, ZONE B6)

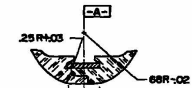
VIEW A-A  
(SH 1, ZONE B8)



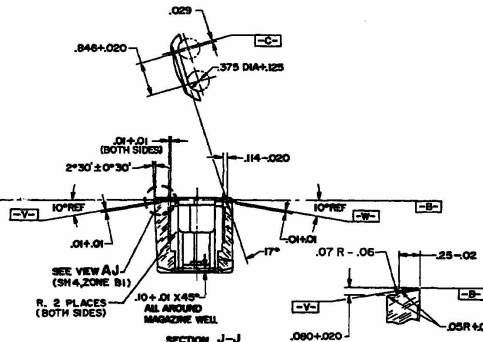
**SECTION F-F**  
**(SH 1, ZONE B5)**



VIEW AA  
(SH 4, ZONE D7)



VIEW AB  
SCALE 2/1  
(SH 4, ZONE B7)



VIEW A J  
(SH 4, ZONE B3)

CURRENT DESIGN ACTIVITY CAGE CODE 19200  
U.S. ARMY  
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER  
PICATINNY ARSENAL, NEW JERSEY 07805-5000

PART NO. 11686426

**STOCK, GUN, SHOULDER**  
(PREMIX)

DATA CODE	CASE CODE	11686426
F	19205	

FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST J1686426

TECHNICAL SPECIFICATIONS		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWING CODE 17 DEC 68		SPONSORING AGENCY SPAINFELD, MA	
1		TOLERANCES ON DIMENSIONS: .010 FRACTIONS .005 IN P		THIRD ANGLE DRAWING	PROPOSED P.A.		
2		DATE: 12/16/68	SEE SHEET 1	DATE: 12/16/68	PROPOSED P.A.		
3	FIG 1686427	RIFLE, M16					
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SMCAR FORM 69, 1 JUL 87(TEMP) REPLACES SMCAR FORM 69, 1 JUN 86(TEMP) WHICH IS OBSOLETE

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## NOTES:

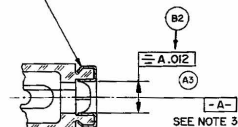
1. THE COMPONENTS OF THE ASSEMBLY SHALL BE IN ACCORDANCE WITH DIMENSIONS SPECIFIED ON THE RESPECTIVE COMPONENT AND/OR PRIOR ASSEMBLY DRAWINGS AND APPLICABLE SPECIFICATIONS, UNLESS OTHERWISE SPECIFIED.

2. FERRULE AND STOCK SHALL BE PERMANENTLY BONDED WITH ADHESIVE, MIL-A-52194. A FINE LINE OF ADHESIVE SHALL BE VISIBLE AT JOINT AFTER BONDING. ADHESIVE SHALL BE PIGMENTED TO APPROXIMATE COLOR FED STD NO. 595, BROWN 30045.

3. LOCATIONS OF DATUMS  $\boxed{-A-}$ ,  $\boxed{-B-}$  AND  $\boxed{-C-}$  ARE ESTABLISHED ON SHEET 1 OF DWG F11686426.

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
A	(1-4) SEC. 80 SA 22975	15 DEC 66	<i>[Signature]</i>
B	(1-2) SEC. 80 RM-14153	4 JUL 67	<i>[Signature]</i>

CRIMP AT ASSEMBLY BOTH SIDES AFTER APPLYING ADHESIVE. SEE NOTE 2.



SECTION A-A

17.235 MAX REF  
17.211 MIN REF

(A2)

$\boxed{-C-}$  SEE NOTE 3

2-BURR - 7790474

SET END OF RIVETS SHALL BE FREE OF CRACKS AND SHALL NOT PROTRUDE ABOVE .94 ± .01 DIM.

(B1)

.94 ± .01

$\boxed{-B-}$   
SEE NOTE 3

(A4)

.936 MAX REF  
.897 MIN REF

STOCK - 11686426

SWIVEL ASSEMBLY - 7267089

2-RIVET - 7790473  
RIVET SECURELY

FERRULE - 7267017  
SEE NOTE 2

FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 11686427

PART NO. 11686427

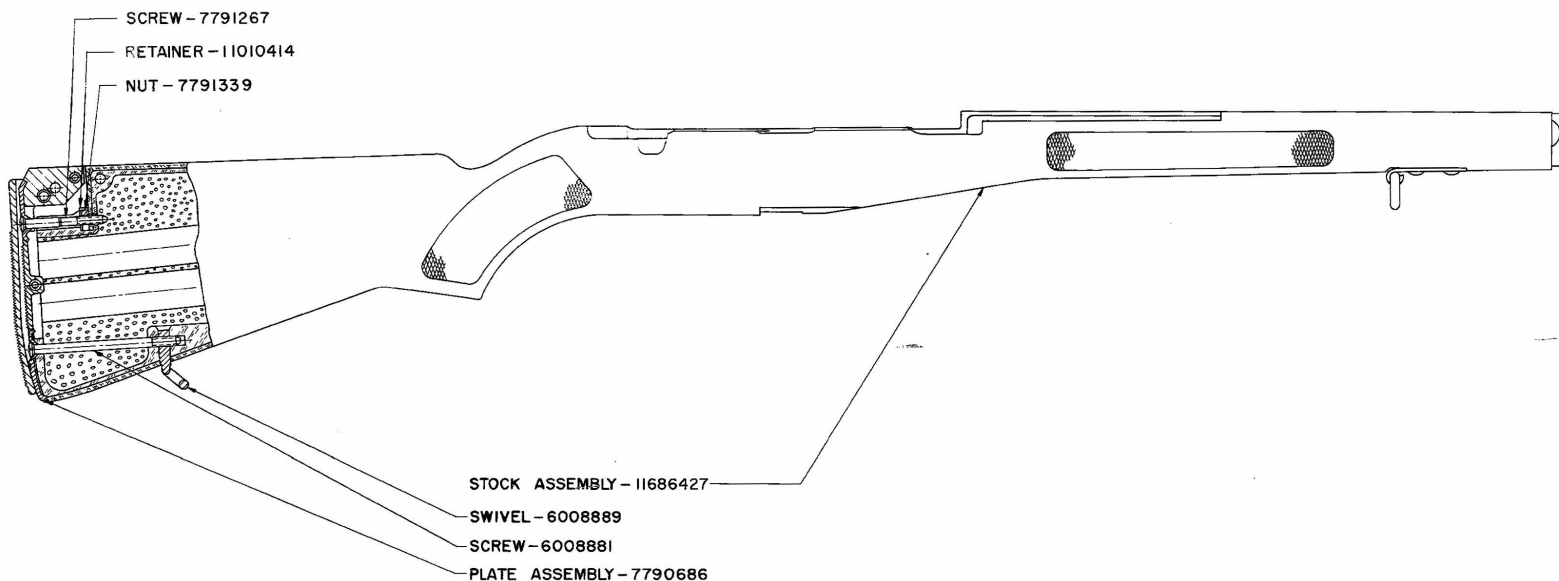
MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE 17 DEC 65 OF DRAWING		DEPT OF THE ARMY	
VP		TOLERANCES ON DECIMALS ±		CHECKER <i>[Signature]</i>		ROCK ISLAND ARSENAL	
TS		FRACTIONS ±		TRICKER <i>[Signature]</i>		ROCK ISLAND ILL 61201	
EL 2		ANGLES ±		CHECKER <i>[Signature]</i>		STOCK ASSEMBLY W/O BUTT PLATE (PREMIX)	
TM	F11686426 TRIPLE, M14	MATERIAL		ENGINEER <i>[Signature]</i>		DWG SIZE CODE 10011 NO.	
BR	SEE ENGINEERING RECORDS	HEAT TREATMENT		SUBMITTER <i>[Signature]</i>		F 19204 11686427	
RM	NEXT ASSY USED ON	FINAL PROTECTIVE FINISH		APPROVED <i>[Signature]</i>		SCALE 1/1 UNIT WT SHEET 1 OF 1	
APPLICATION						REF SAP-27965	

REDUCED SIZE PRINT



NOTES:

1. ALL SCREWS SHALL BE TIGHTENED SECURELY.
2. THE COMPONENTS OF THE ASSEMBLY SHALL BE IN ACCORDANCE WITH DIMENSIONS SPECIFIED ON THE RESPECTIVE COMPONENT AND/OR PRIOR ASSEMBLY DRAWINGS AND APPLICABLE SPECIFICATIONS, UNLESS OTHERWISE SPECIFIED.
3. BEFORE ASSEMBLING SCREW 7791267, THE NUT SHALL HAVE LATERAL AND VERTICAL MOVEMENT INSIDE RETAINER.
4. MIL-W-13855 SHALL APPLY.



REVISIONS			
LTN	DESCRIPTION	DATE	APPROVED
1	1-2 SEE E.O. 82048	11 MAR 68	<i>L.H. Hany</i>
2	1-2 SEE E.O. 82048		
3	1-2 SEE E.O. 82048		
4	1-2 SEE E.O. 82048		
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99	1-2 SEE E.O. 82048		
100	1-2 SEE E.O. 82048		

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND  
DOVER, NEW JERSEY 07801

CODE IDENT NO.

19200

PART NO. 11686428

(A) (B)

FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 11686428

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 17 DEC 65	
TP		TOLERANCES ON	DECIMALS	DRAWN BY	CHECKED BY
TS		FRACTIONS		TRACED BY	CHECKED BY
EL 2		ANGLES		ENGINEER	ENGINEER
BA		MATERIAL		SUBMITTED	
BH		HEAT TREATMENT			
RH		APPLICATION			
		FINAL PROTECTIVE FINISH			
APPROVED		APPROVED			
SPEC PART NO.		SCALE 1/1 UNIT IN. SHEET 1 OF 1			

STOCK ASSEMBLY.  
GUN, SHOULDER  
(PREMIX)

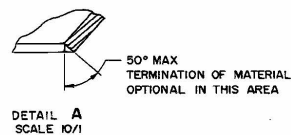
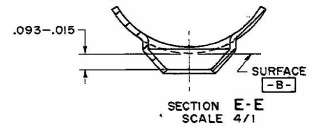
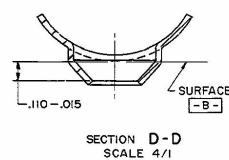
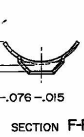
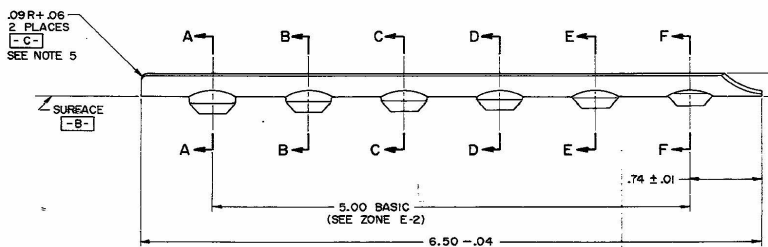
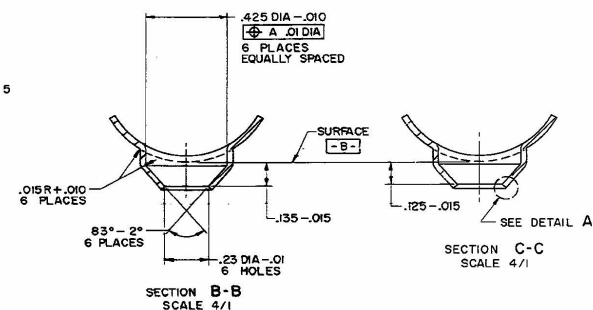
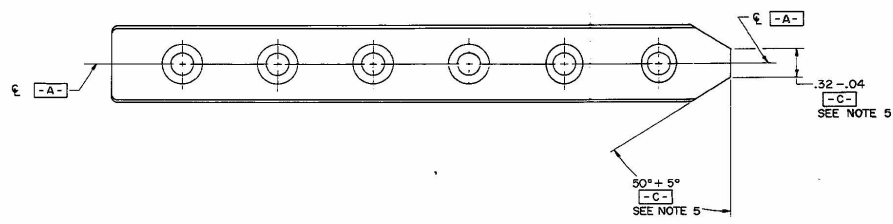
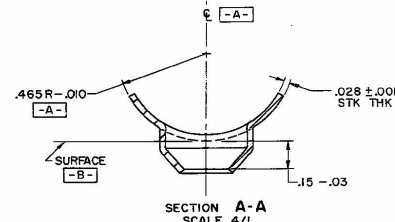
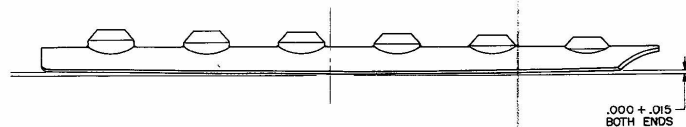
F 19200 11686428

SCALE 1/1 UNIT IN. SHEET 1 OF 1

REF SAF-27964

# NOTES:

1. FINISH  $\sqrt{125}$ , EXCEPT SHEARED SURFACES  $\sqrt{250}$ .
2. EDGES SHALL BE BROKEN  $.003 \pm .005$  UNLESS OTHERWISE SPECIFIED.
3. MATERIAL: STEEL, FED. SPEC QQ-S-700: 1045, 1050, 1055, SPHEROIDIZED ANNEALED.
4. HEAT TREATMENT: HEAT AT 1540° TO 1580°F. OIL QUENCH. TEMPER 30 MINUTES TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
5.  $\boxed{-C-}$  INDICATES DIMENSIONS APPLY PRIOR TO FORMING.
6. MIL-W-13855 APPLIES.



CURRENT DESIGN ACTIVITY FORM NO. 12280  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

PART NO. 11686522

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING	
TEMP		TOLERANCES ON	DECIMALS =	DRAWN BY	CHECKED
TS		FRACTIONS ON	ANGLES =	TRACED BY	CHECKED BY
EL 2		MATERIAL		DESIGNED BY	CHECKED BY
BA		F11686522 RIFLE M4E2		ENGINEERED BY	CHECKED BY
BN		SEE ENGINEERING RECORDS		SUBMITTED BY	CHECKED BY
RM		NEXT ASSY USED ON		APPROVED BY	CHECKED BY
		APPLICATION		DATE	
		APPROVED BY		DATE	
		FINAL PROTECTIVE FINISH		DATE	
		FINISH NO. 5, 3, 1, 2		DATE	
		OF MIL-STD-171		DATE	

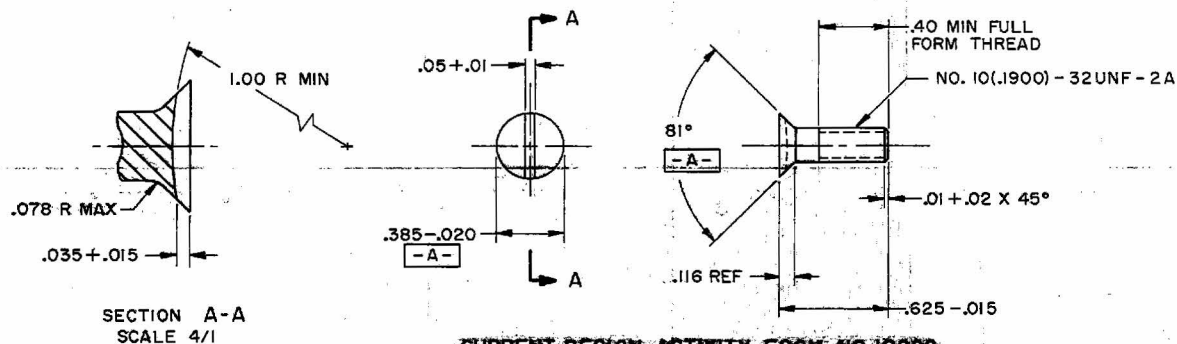
PLATE, BACKING, HANDGRIP

DWG SIZE CODE IDENT NO. 11686522

SCALE 2/1 UNIT WT SHEET 1 OF 1

NOTES:

1. FINISH  $125\sqrt{}$ .
2. EDGES SHALL BE BROKEN  $.003+.005$  UNLESS OTHERWISE SPECIFIED.
3. **-A-** INDICATES TO INTERSECTION OF STRAIGHT LINES.



CURRENT DESIGN ACTIVITY FSCM NO. 19200  
US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

PART NO. 11686523

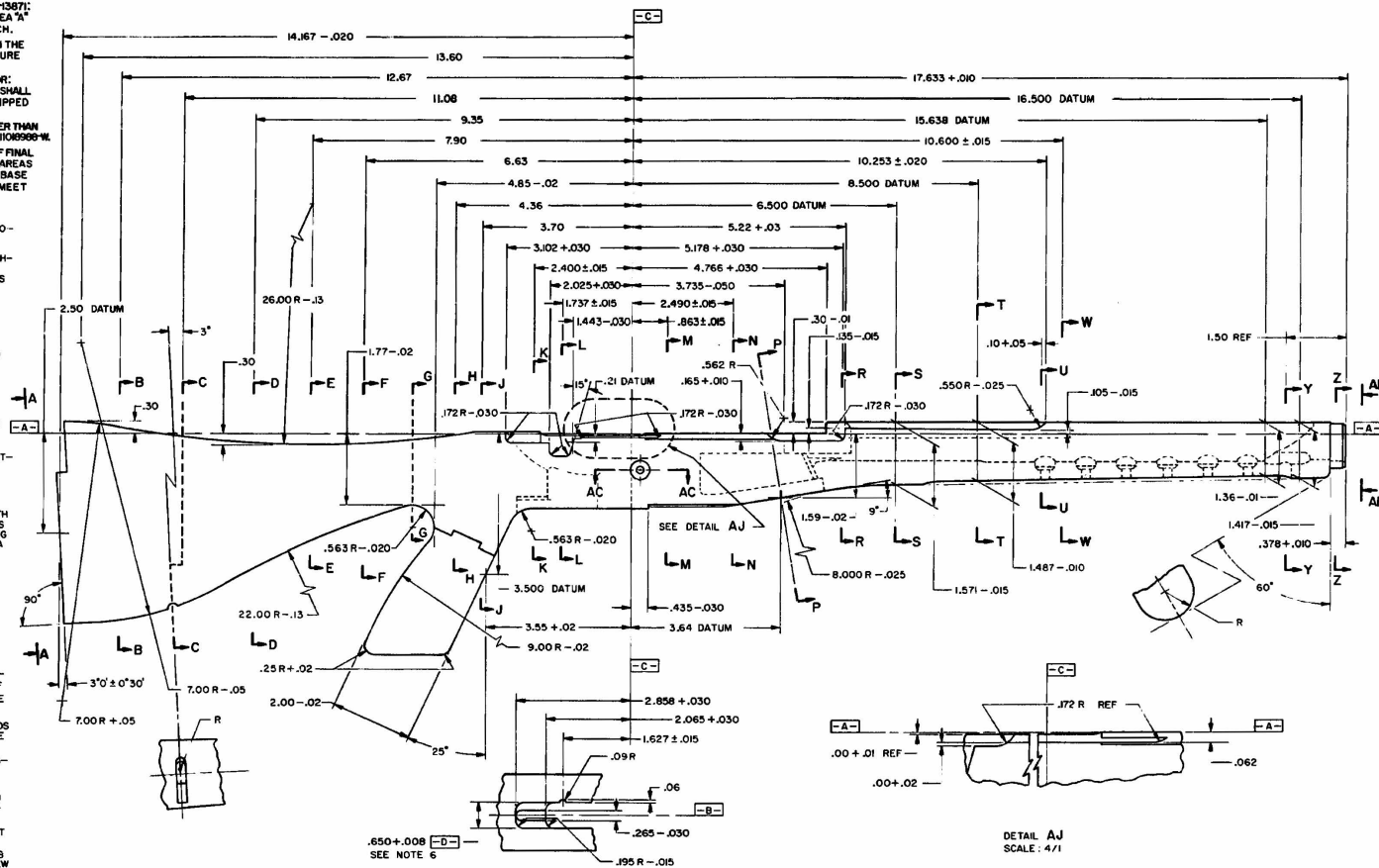
MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 8 APR 66		U. S. ARMY SPRINGFIELD ARMORY SPRINGFIELD, MASS. 01101	
YP		TOLERANCES ON DECIMALS ±		DRAFTSMAN <i>[Signature]</i>	CHECKER <i>[Signature]</i>	SCREW, MACHINE, SLOTTED, COUNTERSUNK HEAD	
TS		FRACTIONS ± ANGLES ± 1°		TRACER <i>[Signature]</i>	CHECKER <i>[Signature]</i>		
EL 2		MATERIAL STEEL, FED. SPEC		ENGINEER <i>[Signature]</i>	ENGINEER <i>[Signature]</i>	DWG SIZE CODE IDENT NO. B 19205 11686523	
RA		ASTM A108 GRADE 1020		SUBMITTED <i>[Signature]</i>			
BH		HEAT TREATMENT		APPROVED <i>[Signature]</i>		SCALE 2/1 UNIT WT SHEET 1 OF 1	
RH		NONE					
NEXT ASSY USED ON		FINAL PROTECTIVE FINISH FINISH					
APPLICATION		5.3.1.2 OF MIL-STD-171					
APPLY PART NO.							

SWESP FORM NO. 1176-1  
20 MAR 64 REV.

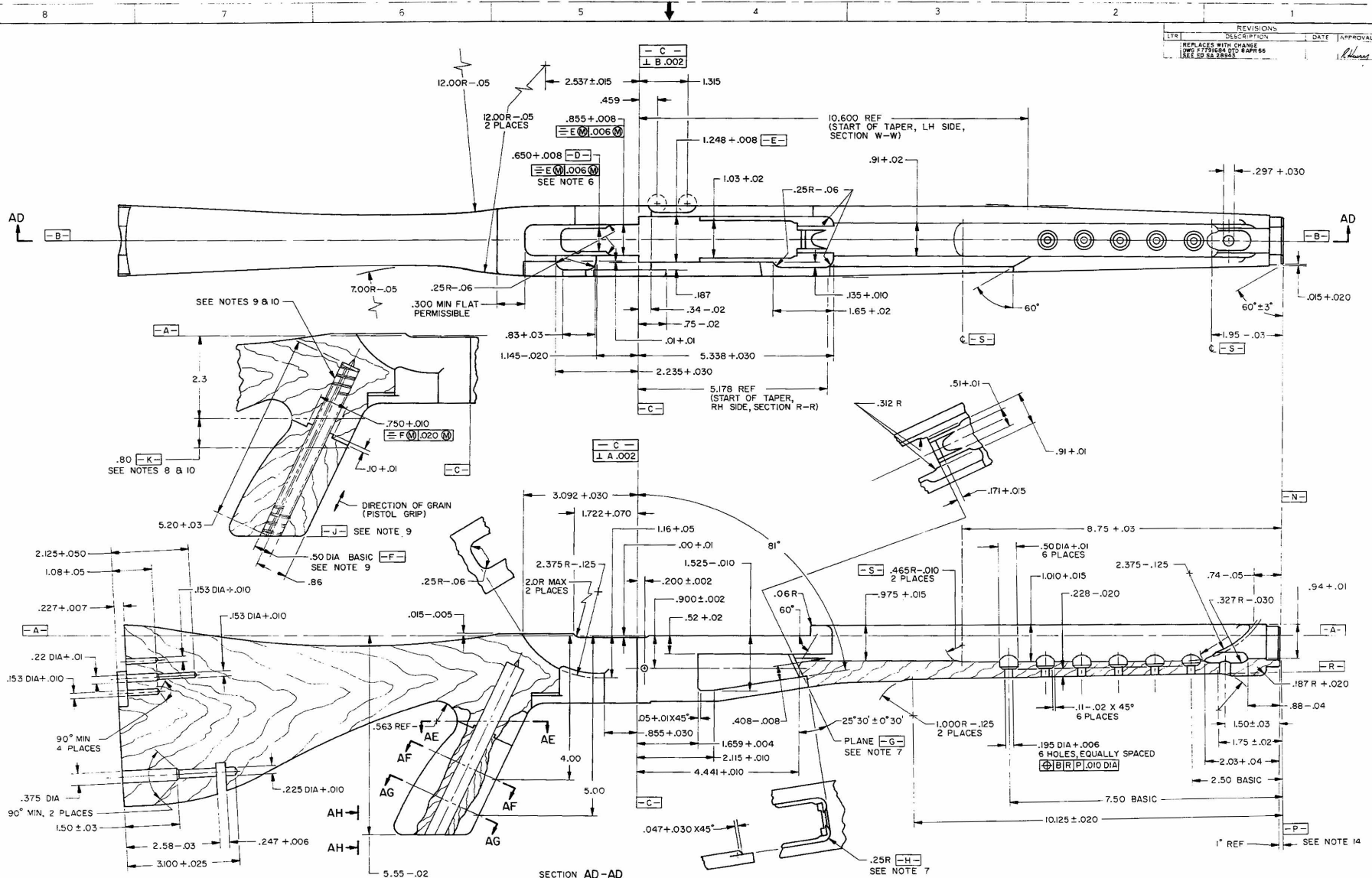
5		4		3		2		1	
<p>NOTES:</p> <p>1. MATERIAL: RUBBER COMPOSITION, MIL-STD-417: TYPE S, CLASS SB, GRADE 715, SUFFIX A, B, E3, F2. COLOR: BLACK 37038 OF FED. STD 595.</p> <p>2. ON ALL EDGES, .01 RADII PERMISSIBLE.</p>						REVISIONS			
						LTR	DESCRIPTION	DATE	APPROVED
							REPLACES WITH CHANGE DWG 11010048 DATED 8 APR 66, SEE EO SA 28943		<i>R. S. Henry</i>
PART NO. 11686524									
MECHANICAL PROPERTIES				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 8 APR 66		U. S. ARMY SPRINGFIELD ARMORY SPRINGFIELD, MASS. 01101	
YP				TOLERANCES ON DECIMALS ±	DRAFTSMAN <i>JPB</i>	CHECKER <i>JP</i>	GROMMET, RUBBER		
TS		F11686528	RIFLE, M14 E2	FRACTIONS ±	TRACER <i>JPB</i>	CHECKER <i>JP</i>			
EL 2		SEE ENGINEERING RECORDS		ANGLES ± 1°	ENGINEER <i>R. S. Henry</i>	ENGINEER <i>JP</i>			
RA				MATERIAL SEE NOTE 1	SUBMITTED				
BH		APPLICATION		HEAT TREATMENT	APPROVED <i>R. S. Henry</i> <i>R. J. Antich</i>		DWG SIZE CODE IDENT NO.		
RH		APPLY PART NO.		FINAL PROTECTIVE FINISH			B 19205	11686524	
						SCALE 4 / 1		UNIT WT SHEET 1 OF 1	

SWESP FORM NO. 1176-1  
20 MAR 64 REV.

- UNLESS OTHERWISE SPECIFIED, CORNERS AND EDGES SHALL BE ROUNDED TO MAXIMUM RADIUS SHALL BE .01R MAX.
2. MATERIAL: WOOD SPEC MIL-M-13871; TYPE (WALNUT) CRITICAL AREA "A" (SEE FIG. 3) SHALL BE .005" THICK.
3. ALL DIMENSIONS APPLY WHEN THE STOCK HAS 6% TO 8% MOISTURE CONTENT.
4. PROTECTIVE FINISH AND COLOR: A. PROTECTIVE FINISH SHALL BE NO. 28.7 OF MIL-STD-171 (DIPPED MINIMUM OF 3 MINUTES). B. COLOR SHALL BE GREY TO MATCH COMPARISON COLOR GAGE NO. 10189900-W.
5. PRIOR TO APPLICATION OF FINAL PROTECTIVE FINISH, LIGHT AREAS SHALL BE STAINED (SPIRIT BASE STAIN) TO MEET COLOR REQUIREMENT.
6. AFTER APPLICATION OF PROTECTIVE FINISH STOPS SHALL BE FREE FROM CROCK, SPOTS, GLOSSY PATCHES, STREAKS, OR OTHER CONTACT MARKS, STICKINESS AND CRAZING. EXTERIOR SURFACE FINISHES SHALL BE SMOOTH AND EXHIBIT NO BUILD-UP OR RAISED GRAIN.
7. DIMENSIONS  $\begin{bmatrix} -D- \end{bmatrix}$  SHOWN ON SHEET 1  $\begin{bmatrix} -D- \end{bmatrix}$  AND SHEET 2  $\begin{bmatrix} -D- \end{bmatrix}$  ARE DIMENSIONAL DIMENSIONS.
- 7.00+0.01 MISMATCH PER MINIMUM RADIUS  $\begin{bmatrix} -M- \end{bmatrix}$  SHEET 2 ZONE A-3,  $\begin{bmatrix} -H- \end{bmatrix}$  SHEET 1 ZONE B-3,  $\begin{bmatrix} -G- \end{bmatrix}$  SHEET 2 ZONE B-3.
8. JOINT BETWEEN HANDRIIP AND CROCK MAY BE ADJUSTED WITHIN AREA  $\begin{bmatrix} -K- \end{bmatrix}$ . SHEET 2 ZONE C-7.
9. DO NOT BURCH, MARK OR WALNUT. SPIRAL GROOVES, APPROX 1/4 INCH PITCH WITH TWO LONGITUDINAL GROOVES 180° APART, 50 DIA X 5.5 LONG SHALL BE FITTED INTO DIA CROCK. FINISH SHALL BE FINISHED FLUSH WITH BOTTOM SURFACE  $\begin{bmatrix} -J- \end{bmatrix}$ .
10. ADHESIVE SHALL CONFORM TO FED. SPEC MMMA-A-181. ADHESIVE SHALL BE APPLIED TO SHEET 1 IN ACCORDANCE WITH MANUFACTURERS SPECIFICATIONS.
11. DATUM PLANE  $\begin{bmatrix} -A- \end{bmatrix}$  ESTABLISHED AT INTERSECTION OF DIMENSION  $\begin{bmatrix} -E- \end{bmatrix}$  AND ANGLE  $\begin{bmatrix} -L- \end{bmatrix}$  (SEE SECTION M-M, SHEET 3 ZONE C-3) EXTENDS FROM BUTT END TO MUZZLE END OF CROCK.
12. DATUM PLANE  $\begin{bmatrix} -B- \end{bmatrix}$  IS ESTABLISHED BY CENTERLINE OF DIMENSION  $\begin{bmatrix} -M- \end{bmatrix}$  (VIEW A-A) AND SECTION 3 ZONE D-6) AND CENTERLINE OF DIMENSION  $\begin{bmatrix} -E- \end{bmatrix}$  (SHEET 2 ZONE E-4) AND EXTENDS TO BUTT END OF CROCK.
13. VIEW A-A AND SECTIONS B-B THRU G-G, SECTION 2-Z, VIEW A-A AND SECTIONS A-A THRU A-H-AH ARE SYMMETRICAL ABOUT  $\begin{bmatrix} -B- \end{bmatrix}$ .
14. DATUM LINE  $\begin{bmatrix} -P- \end{bmatrix}$  ORIGINATES AT THE INTERSECTION OF DATUM LINE  $\begin{bmatrix} -A- \end{bmatrix}$  AND SURFACE  $\begin{bmatrix} -N- \end{bmatrix}$  AND IS PERPENDICULAR TO SURFACE  $\begin{bmatrix} -R- \end{bmatrix}$ .

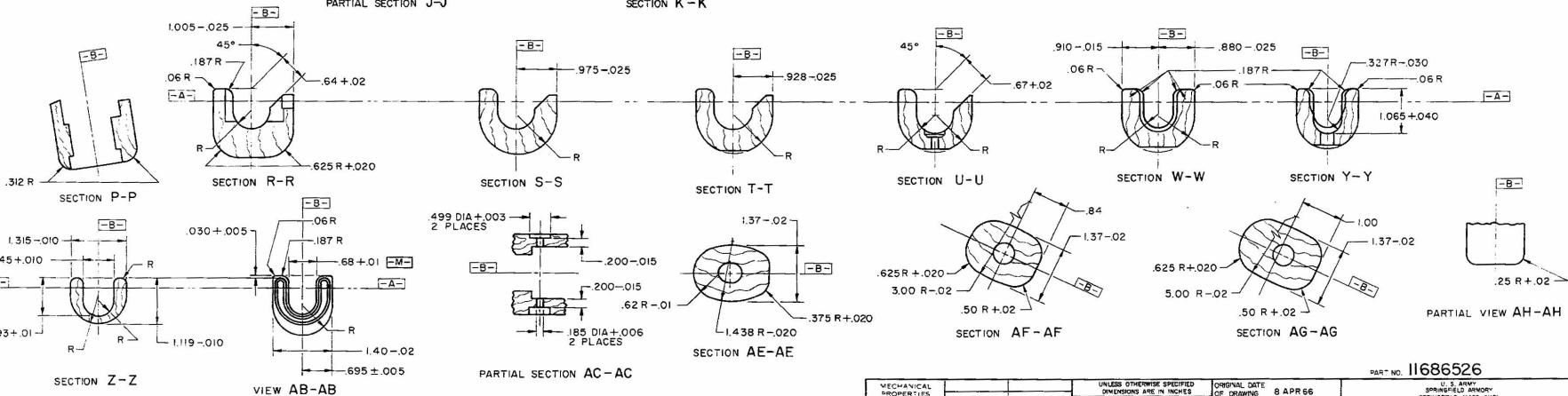
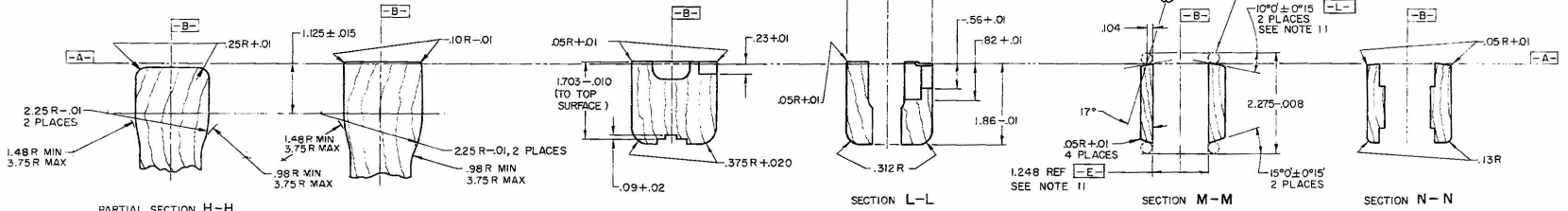
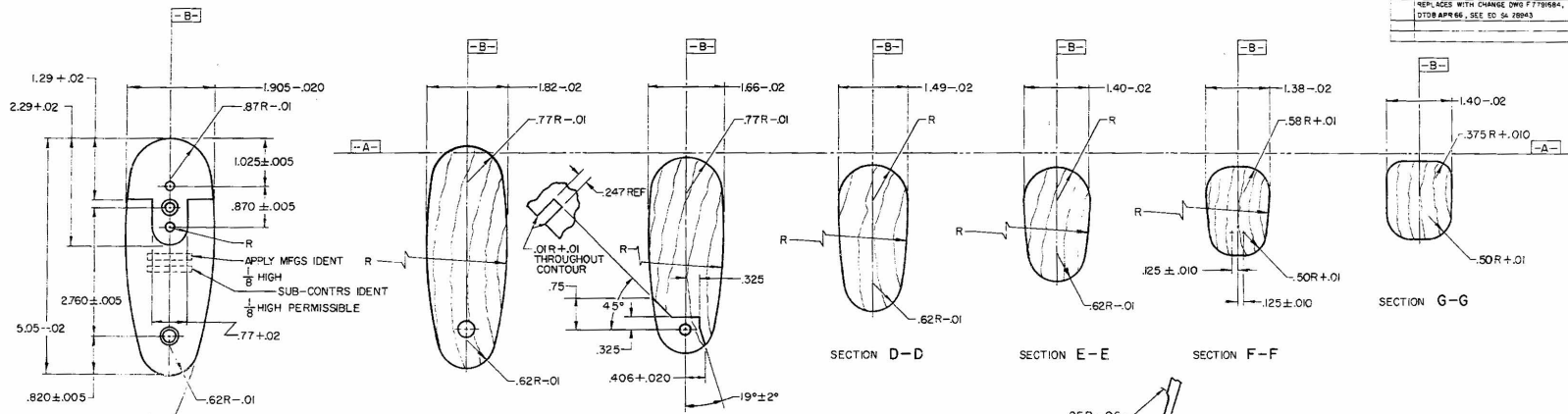


MECHANICAL PROPERTIES		IF/LESS INFORMATION SPECIFIED OTHERWISE ARE IN POUNDS		ORIGINAL DATE OF DRAWING		PART NO. 1186526		U.S. ARMY SPRINGSFIELD ARMOY SPRINGSFIELD MASS 0101	
TP	F11680527	RIFLE M16		TOLERANCES ON DECIMALS = 01		DRAWN BY <i>[Signature]</i>		CHECKED BY <i>[Signature]</i>	
EL2		MATERIAL		FINISH		DRAWN BY <i>[Signature]</i>		CHECKED BY <i>[Signature]</i>	
BA	SEE ENGINEERING RECORDS			SEE NOTE 2		TOLERANCES		FINISH	
BN	HEAT TREAT	HEAT TREATMENT		HEAT TREATMENT		TOLERANCES		FINISH	
	APPLY PART-99	APPLICATION		APPLICATION		TOLERANCES		FINISH	
RM		FINAL PROTECTIVE FINISH		FINAL PROTECTIVE FINISH		TOLERANCES		FINISH	
		SEE NOTE 4		SEE NOTE 4		TOLERANCES		FINISH	
				APPROVED <i>[Signature]</i>		DATE		11686526	
				DATE		19205 F		11686526	



MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS: .01 ANGLES: 16		ORIGINAL DATE OF DRAWING 8 APR 66		PART NO. 11686526	
YP				DRAFTSMAN	CHECKER	U. S. ARMY SPRINGFIELD ARMOY SPRINGFIELD, MASS. 01101	
TS				TRACER	CHECKER		
EL 2						STOCK, GUN, SHOULDER	
RA	F11686527	RIFLE, M14E2	SEE SHEET 1				
BH		SEE ENGINEERING RECORDS	HEAT TREATMENT			Dwg Size: 1000 (Dwg) No. F 19205 11686526	
RH		NOT USED ON APPLICATION	FINAL PROTECTIVE FINISH SEE SHEET 1				
				APPROVED R. J. Henry		SCALE 1/1 UNIT: INCHES SHEET 2 OF 3	

REVISIONS			
LT#	DESCRIPTION	DATE	APPROVED
1	REPLACES WITH CHANGE DWG F779584, 1278 APR 66, SEC 10 10043		<i>Library</i>



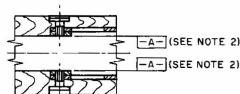
MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 8 APR 66	
ST		TOLERANCES ON DECIMALS ±.01		DRAFTSMAN	CHECKER
TS	F 11685527	FRACTIONS ±.01		TRACER	Y.S.C.
EL		ANGLES ±1°		ENGINEER	CHECKER
SA	SEE ENGINEERING RECORDS			DESIGNER	Y.S.C.
BM	NEXT ASS'Y USED ON APPLICATION			SUBMITTER	Y.S.C.
RM				APPROVER	Y.S.C.
		HEAT TREATMENT			
		FINAL PROTECTIVE FINISH			
		SEE SH 1			

PART NO. 11686526		U. S. ARMY SPRINGFIELD ARMOY SPRINGFIELD, MASS. 01101	
STOCK, GUN, SHOULDER			
19205	F	11686526	
SCALE 1/1	UNIT IN	INCHES	3/4

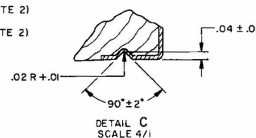
NOTES:

1. ALL SCREWS SHALL BE TIGHTENED SECURELY.
2. PROTRUSION OF THREAD END OF SCREW BEYOND LINER SURFACES  $\overline{A-A}$  SHALL NOT EXCEED .001. (SEE SECTION A-A).

REVISIONS		DATE	APPROVED
1/1	REPLACES WITH CHANGE DWG 7779479, 010 8 APR 66. SEE ED 6428943		<i>Henry</i>



SECTION A-A



DETAIL C  
SCALE 4/1

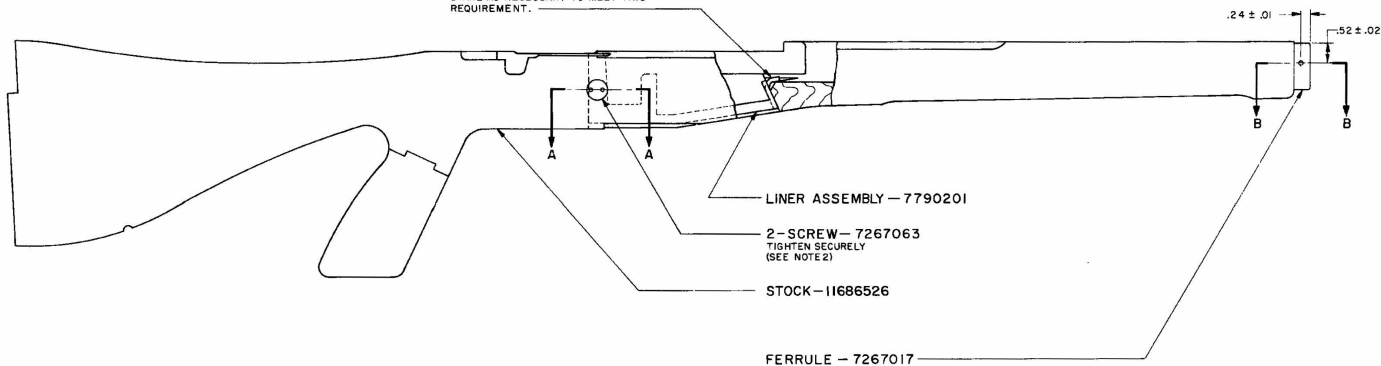
PUNCH AT ASSEMBLY  
BOTH SIDES



SECTION B-B

SEE DETAIL C

LINER PRONGS SHALL CONTACT STOCK.  
STAKE AS NECESSARY TO MEET THIS  
REQUIREMENT.



LINER ASSEMBLY - 7790201

2 - SCREW - 7267063  
TIGHTEN SECURELY  
(SEE NOTE 2)

STOCK - 11686526

FERRULE - 7267017

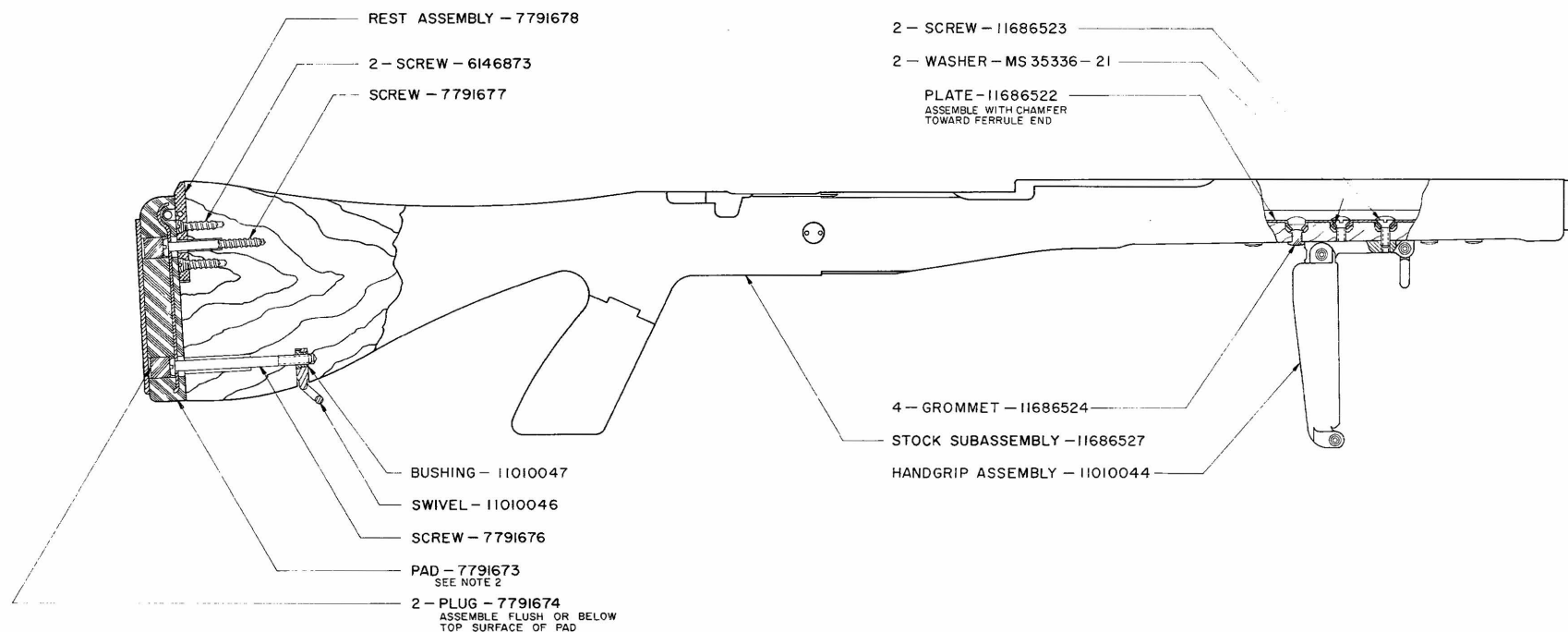
FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 11686527

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING: 8 APR 66		PART NO. 11686527	
1/1		TOLERANCES ON DECIMALS	ANGLES	DRAFTSMAN	CHECKER	SPRINGFIELD ARMOY SPRINGFIELD, MASS. 01101	
1/2	F11686526 RIFLE, M14 E2	FRACTIONS		TRACER	75C	STOCK SUBASSEMBLY, GUN, SHOULDER	
1/4	SEE ENGINEERING RECORDS	MATERIAL		TOLERANCE	75C		
1/8	NEXT ASST USED ON APPLICATION	HEAT TREATMENT		APPROVED	<i>Henry</i>	CODE IDENT NO. DWG NO.	
1/16	APPLY PART NO.	FINAL PROTECTIVE FINISH		19205	F	11686527	
				SCALE 1/1		SHEET 1 OF 1	



1. ALL SCREWS SHALL BE TIGHTENED SECURELY.
2. PAD SHALL BE LOCATED CENTRAL WITH SIDES OF STOCK.

REVISIONS			
LT	DESCRIPTION	DATE	APPROVED
	REPLACES WITH CHANGE DWD 7771671, DTD 8 APR 66, SEE 150 58 12840		<i>R. H. Lewis</i>



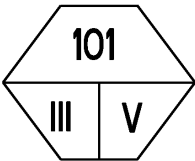
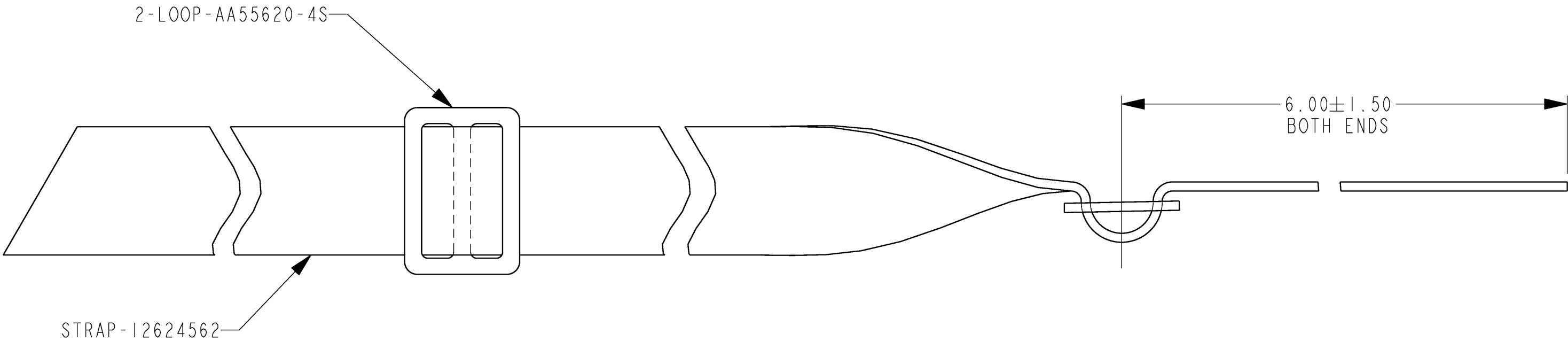
FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 11686528

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 8 APR 66		PART NO. 11686528	
YP		TOLERANCES ON DECIMALS		DRAFTSMAN	CHECKER	17.5 ARMY SPRINGFIELD ARMOY SPRINGFIELD, MASS. 01101	
TS		FRACTIONS		TRACER	CHECKER	STOCK ASSEMBLY, GUN, SHOULDER	
EL 2		ANGLES		ENGINEER	CHECKER		
RA	F11010000 RIFLE M14E2	MATERIAL		SUBMITTED			
BH	SEE ENGINEERING RECORDS	HEAT TREATMENT		APPROVED			
RH	NEXT ASSY USED ON	FINAL PROTECTIVE FINISH					
APPLICATION				APPROVED		DWS 1077 CROSS (DATE NO)	
						F 19205 11686528	
						SCALE 1/2" = 1" UNIT WT SHEET 1 OF 1	

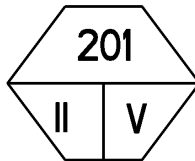
NOTES

1. MIL-W-13855 APPLIES
2. QUALITY ASSURANCE PROVISION REQUIREMENTS PER DRAWING 12993884 APPLY.

REVISIONS				
MODEL REV	DRAW REV	DESCRIPTION	DATE(YEAR-MO-DA)	APPROVED
N/A	-	PRODUCTION RELEASE ERR W5S0107	1986-01-24	
N/A	A	NOR GIS9451 / 1991-04-29	1991-06-05	GHS/SR
N/A	B	NOR L7S2000 / 1997-02-14	1997-03-06	JB
-	C	NOR L2S3067 / 2002-11-12	2003-02-11	JJW
A	D	NOR L05S2001 / 2005-02-08	2005-03-04	BMG



PARTS MISSING OR IMPROPERLY ASSEMBLED

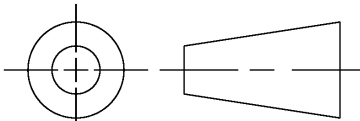
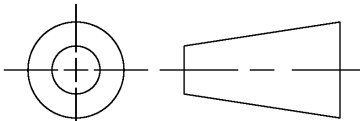


WORKMANSHIP

THIS DRAWING WAS GENERATED FROM A SOLID MODEL  
AND IS CAD MAINTAINED. CHANGES SHALL BE  
INCORPORATED BY THE DESIGN ACTIVITY.

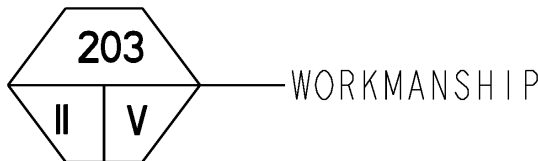
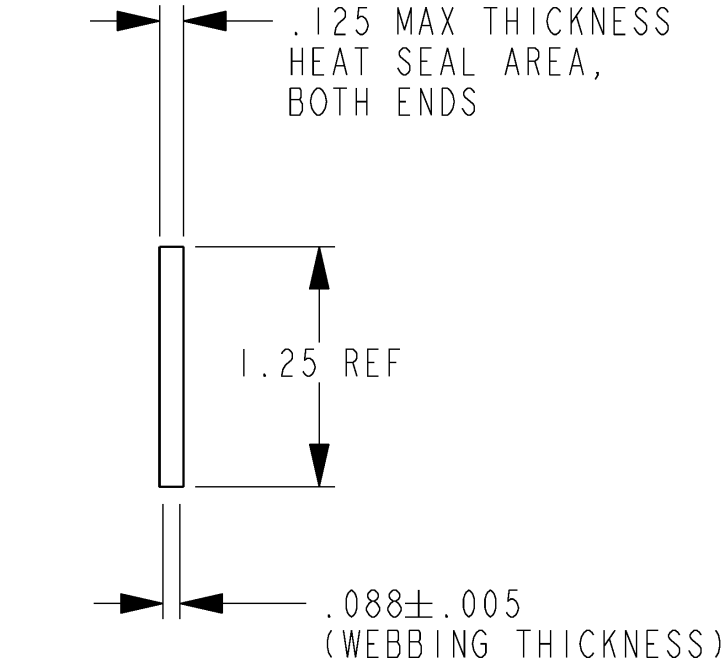
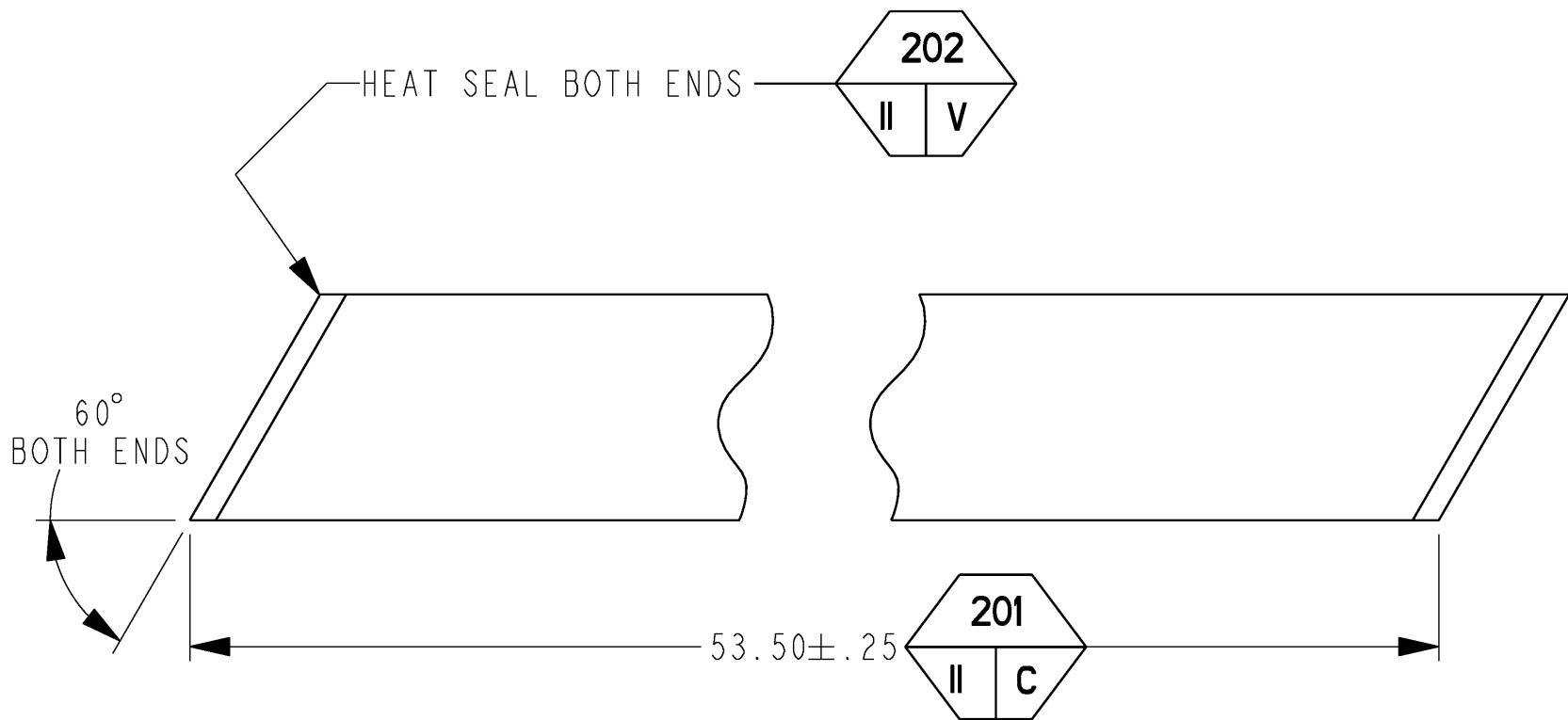
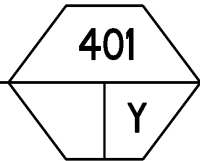
PART NO. 12624561

DISTRIBUTION STATEMENT A:  
APPROVED FOR PUBLIC RELEASE;  
DISTRIBUTION IS UNLIMITED.

PMIC		F7267000		DO NOT SCALE DRAWING  UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES  TOLERANCE ON ANGLES ± ° 2 PLACE DECIMALS ± 3 PLACE DECIMALS ±		CONTRACT NUMBER  CONTRACTOR		DESIGN ACTIVITY US ARMY ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER PICATINNY ARSENAL, NEW JERSEY 07806-5000					
		F7265698											
		B8426167											
MECHANICAL PROPERTIES			MI6A4	THIRD ANGLE PROJECTION  		DRAWN BY S. GALL - ESERV		DATE(YEAR-MO-DA) 1986-01-24		SLING, ADJUSTABLE, SMALL ARMS			
			MI6A3			CHECKER J. MACON-ESERV		ENGINEER J. WINDHAM					
YP		F8448500	SHOTGUN, 12 GA			ENGINEER L. KO		QUALITY ENGINEER E. SESE		SIZE C CAGE CODE 19200 DWG NO. 12624561			
TS						DRAWING APPROVAL L. BRUNTON 2002-11-08							
EL2			RIFLE, M14			DESIGN APPROVAL R. ELBE 2002-11-08		SCALE 1 UNIT WT. 0.204 SHEET 1 OF 1					
RA			MI6A1										
BH		NEXT ASSY	USED ON										
RH		APPLICATION		MATL ENGR		MODELED BY S. GALL - ESERV							

NOTES

1. APPLICABLE STANDARDS/SPECIFICATIONS:  
A. MIL-W-13855
2. MATERIAL: WEBBING, TEXTILE, BULKED NYLON, TYPE II, A-A-55301, EXCEPT AS NOTED, COLOR BLACK, NO. 37038 OF FED-STD-595.
3. QUALITY ASSURANCE PROVISION REQUIREMENTS PER DRAWING 12993884 APPLY.



THIS DRAWING WAS GENERATED FROM A SOLID MODEL AND IS CAD MAINTAINED. CHANGES SHALL BE INCORPORATED BY THE DESIGN ACTIVITY.

PART NO. 12624562

DISTRIBUTION STATEMENT A:  
APPROVED FOR PUBLIC RELEASE;  
DISTRIBUTION IS UNLIMITED.

PMIC				DO NOT SCALE DRAWING		CONTRACT NUMBER		DESIGN ACTIVITY		
				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACTOR		US ARMY ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER PICATINNY ARSENAL, NEW JERSEY 07806-5000		
MECHANICAL PROPERTIES				TOLERANCE ON ANGLES ± ° 2 PLACE DECIMALS ± 3 PLACE DECIMALS ±		DRAWN BY R. SIERENS -ESERV	DATE(YEAR-MO-DA) 1986-01-24	STRAP		
YP			MI6A4	THIRD ANGLE PROJECTION		CHECKER J. MACON-ESERV	ENGINEER J. WINDHAM			
TS			MI6A3			ENGINEER L.KO	QUALITY ENGINEER E. SESE			
EL2			SHOTGUN, 12 GA			DRAWING APPROVAL		SIZE C	CAGE CODE 19200	DWG NO. 12624562
RA			RIFLE, MI4			L. BRUNTON 2002-11-08				
BH		12624561	MI6A1	NEXT ASSY		DESIGN APPROVAL		SCALE 1	UNIT WT. 0.303	SHEET 1 OF 1
RH				APPLICATION		MATL ENGR	MODELED BY R. SIERENS - ESERV			
						R. ELBE 2002-11-08				



# RIFLE, 7.62-MM, M 14



## GUNsmith

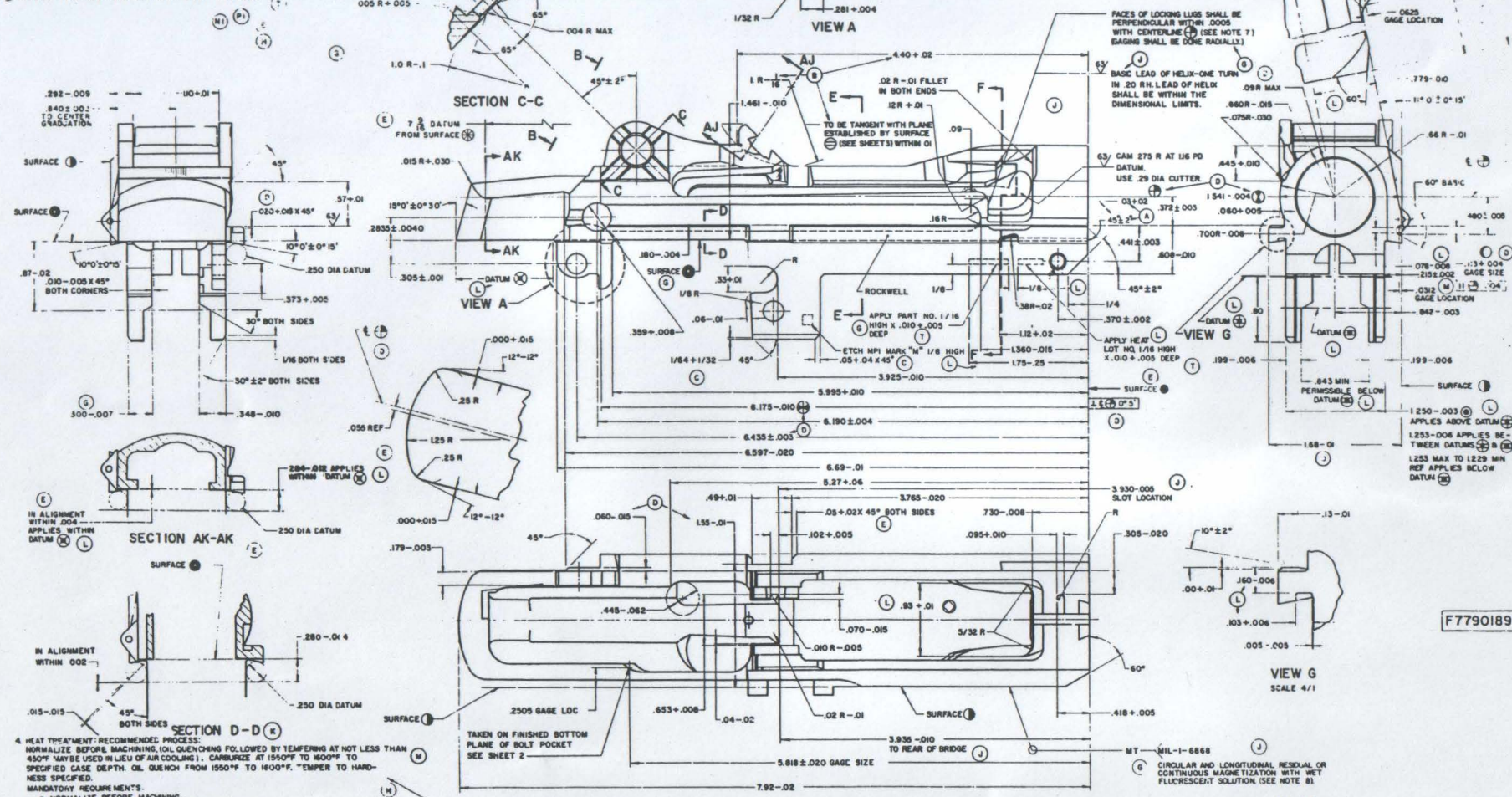
60 Valley Farms, Arizona 85291-0060



# M-14 RECIEVER

## NOTES

- 1 FINISH 125 EXCEPT AS NOTED.
- 2 MATERIAL, STEEL, SPEC QQ-S-624, 86200 EXCEPT RESULPHURIZED (1.01% P, 0.03% S) 250% 1 BURDUALITY, WELDABILITY OF STEEL SHALL BE CONTROLLED, AS REQUIRED, TO SUIT MANUFACTURER'S HEAT TREATMENT PROCESS AND ASSURE THAT SPECIFIED MANDATORY PHYSICAL REQUIREMENTS ARE MET. MIN. SIZE "OR FINER."
- 3 UNLESS OTHERWISE SPECIFIED:
  - a. ALL EXPOSED EXTERIOR EDGES AND CORNERS SHALL BE BLOWN UP & 1/8".
  - b. ALL INTERIOR CORNERS SHALL BE ROUNDED WITH A FILLET OF 0.05 R ± 0.01.
  - c. ALL O-RING FEES AND CURNERS SHALL BE MINUTE, 0.05 ± 0.01.
- 4 DIM 125 APPLIES TO LENGTH 125.
- 5 125 APPLIES TO LENGTH 125.
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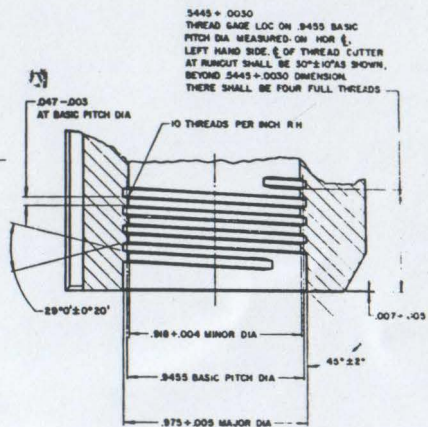
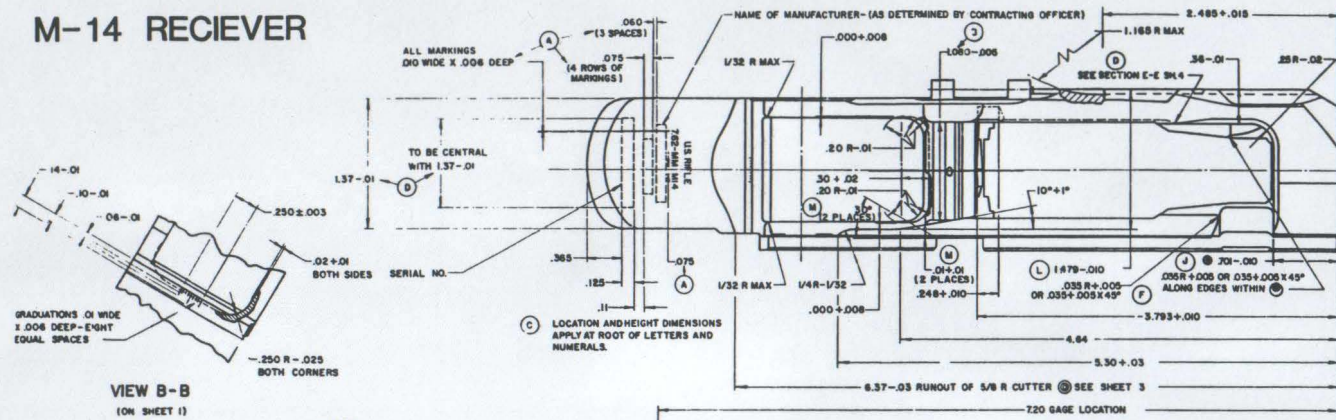
4. HEAT TREATMENT: RECOMMENDED PROCESS: NORMALIZE BEFORE MACHINING, OIL QUENCHING FOLLOWED BY TEMPERING AT NOT LESS THAN 400°F. MAY BE USED IN LIEU OF AIR COOLING; CARBURIZE AT 1500°F TO 1600°F TO SPECIFIED CASE DEPTH. OIL QUENCH FROM 1550°F TO 1600°F. TEMPER TO HARDNESS SPECIFIED.
- MANDATORY REQUIREMENTS:
  - a. NORMALIZE BEFORE MACHINING.
  - b. CARBURIZE TO CASE DEPTH 0.02 TO 0.08.
  - c. TEMPER ONE HOUR MINIMUM AT 350°F TO 400°F.
  - d. CORE, ROCKWELL HARDNESS 128 TO 132. CASE, SURFACE, ROCKWELL HARDNESS 041 TO 071 OR (REFERENCE METHOD) 30H-34 MINIMUM ON A PROPERLY PREPARED SURFACE.
  - e. MICROSTRUCTURE OF CORE SHALL NOT CONTAIN MORE THAN 10% FREE FERRITE AFTER HEAT TREATMENT.
  - f. THE USE OF A STRAIGHT CYANIDE BATH OR GAS PROCESSES SHALL NOT BE PERMITTED.
8. AFTER HEAT TREATMENT, EACH RECEIVER SHALL BE FREE FROM CRACKS, SEAMS AND OTHER INJURIOUS DEFECTS AS DETERMINED BY MAGNETIC PARTICLE INSPECTION USING A STANDARD 5 TURN MAGNETIZING COIL WITH A CURRENT OF 400 TO 500 AMPERES.
9. MIL-81355 SHALL APPLY.

F7790189

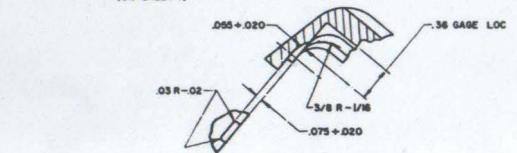
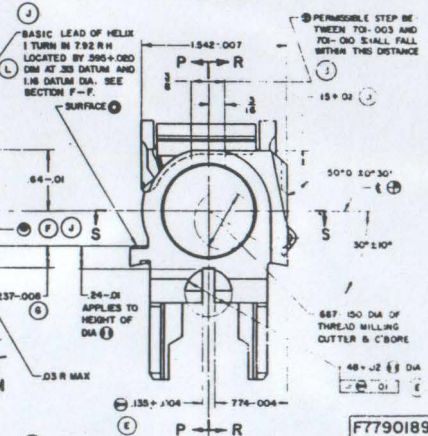
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PART NO. 7790189



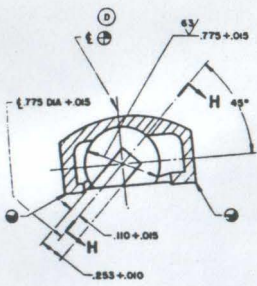
# M-14 RECIEVER



SECTION S-S  
SCALE 4/1

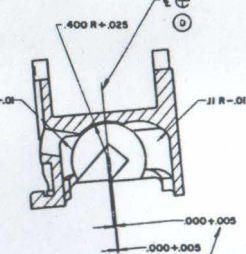


SECTION H-H



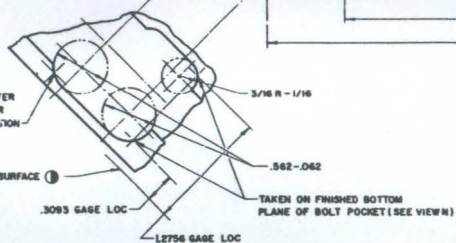
SECTION J-J

NOTE: AT BREAK CORNERS TO APPROX OR NO SCRATCH LINES TO RUN CROSSWISE OF THE CORNER BEING ROUNDED.

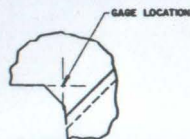


SECTION K-K

THE .775 DIA+.015 (SECTION J-J) AND THE 400 R+.025 (SECTION K-K) MUST BE HELD WITHIN .005 OF EITHER SIDE OF BARREL L AS SHOWN IN SECTION K-K



SECTION R-R



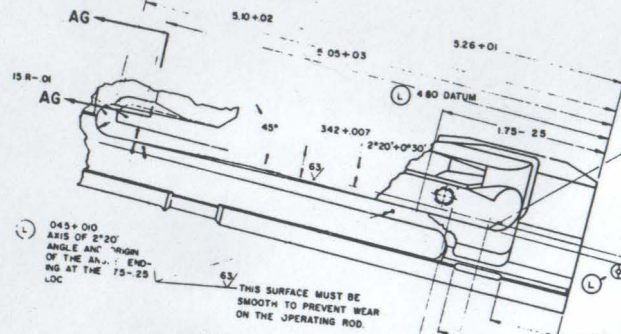
VIEW N

SCALE: 10/1



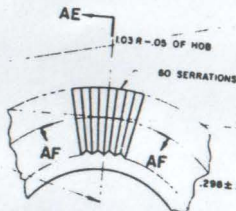
# M-14 RECIEVER

17R-03



THIS SURFACE MUST BE SMOOTH TO PREVENT WEAR ON THE OPERATING ROD.  
SHARP TO .008 R MAX.  
LEAD OF HCB .03/25  
-120°0'±0°15'

SECTION AF-AF

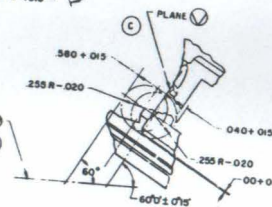


SERRATIONS TO BE RADIAL WITH CENTER WITHIN .005

DEPTH OF SERRATIONS SHALL NOT BE LESS THAN .008

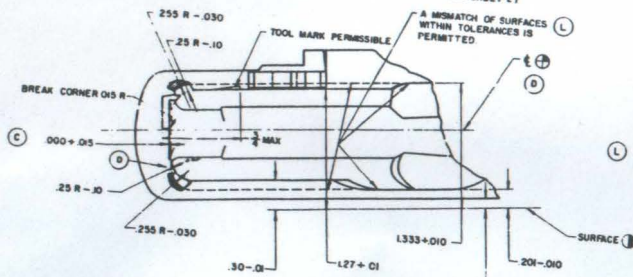
VIEW AG (ON SHEET 3) SCALE 10/1

SECTION AE-AE



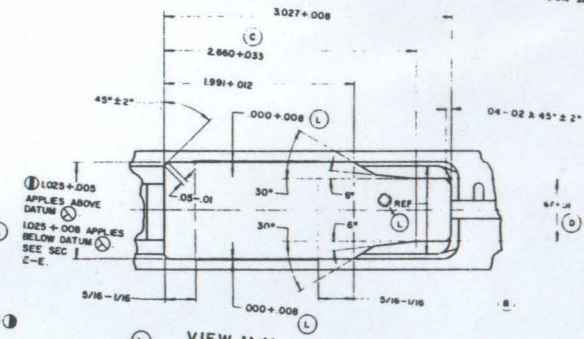
SECTION F-F (ON SHEET 1)

VIEW AH-AH (ON SHEET 2)

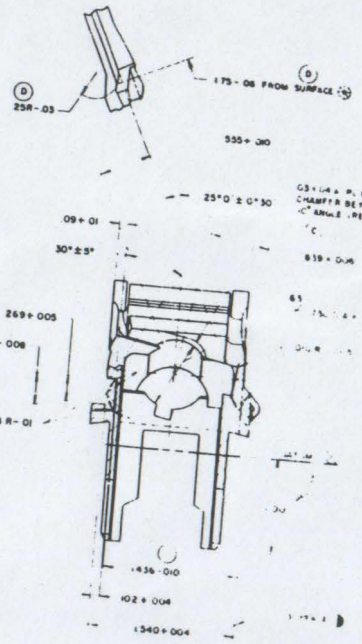


VIEW L-L (ON SHEET 2)

SECTION AG-AG (ROTATED 11°)

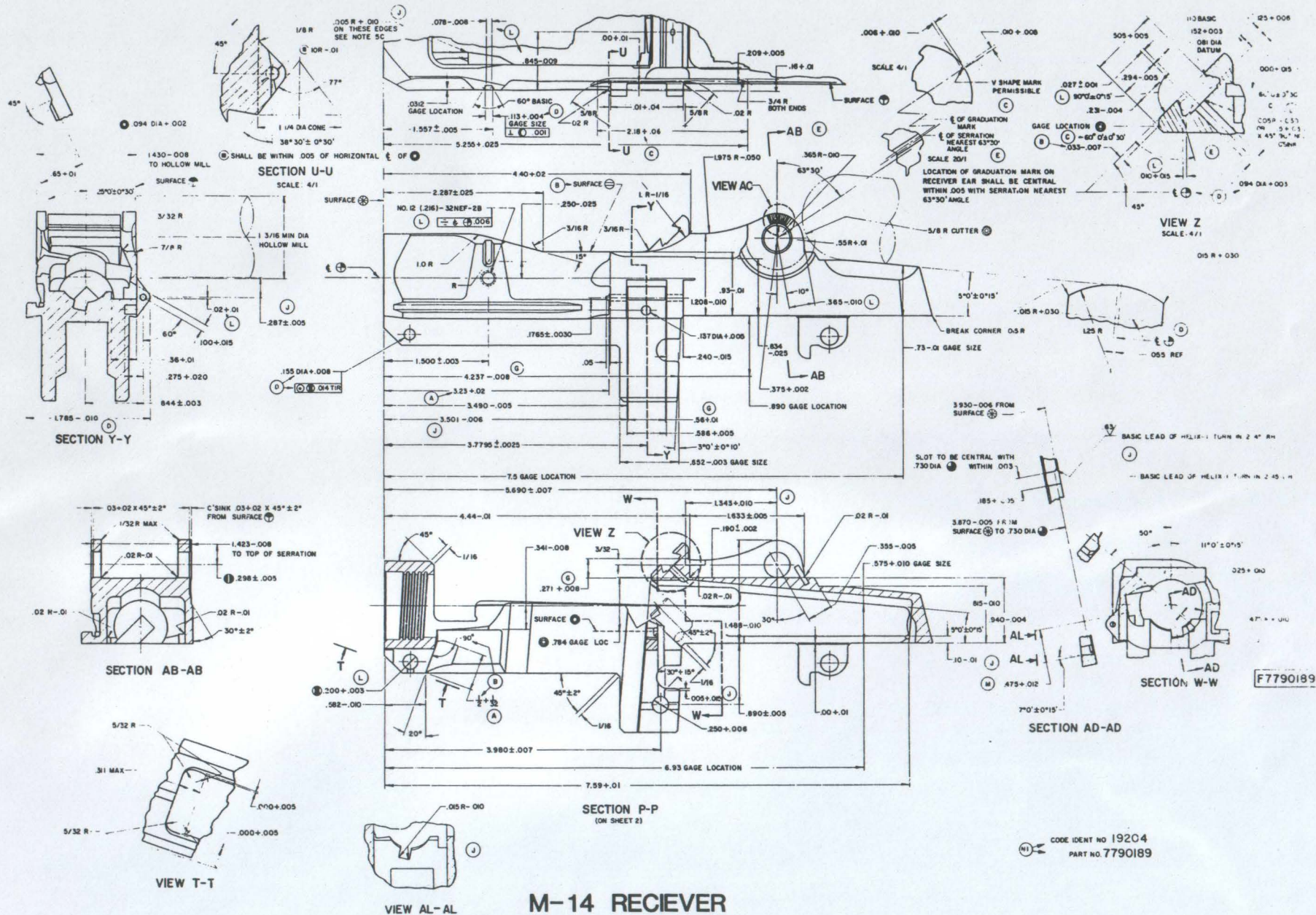


VIEW M-M (ON SHEET 2) (SEE SHEET 1)



SECTION E-E (ON SHEET 1)











#### USMC M40 Sniper Rifle

Caliber: 308 Winchester (7.62x51mm NATO)  
Magazine: 1 round, removable box  
Length: 43.75 in  
Weight: 50.2 pounds  
Barrel Length: 24 inches  
Operation: Bolt-action  
Optics: Bushfield 3x-9x Telescope  
Standardized: April 1960  
Production: 991

#### US Rifle, Sniper, XM21

Caliber: 308 Winchester (7.62x51mm NATO)  
Magazine: 10 round detachable box  
Length: 44.75 in  
Weight: 50.3 pounds  
Barrel Length: 22 inches  
Operation: Bolt-action  
Optics: Bushfield 3x-9x 30 Telescope  
Standardized: September 1968  
Production: 1,000 (estimated)

